CS-61-054

CONVAIR MODEL 30

OVERHAUL MANUAL

MODEL 30

GENERAL DYNAMICS | CONVAIR

SAN DIEGO, CALIFORNIA

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Chapter 23-5-4

SERVICE INTERPHONE JACK BOX

(Pan Air Electronics Part No. JAIOD)

1. Description and Operation

A. This section contains overhaul instructions for the service interphone jack box, part number 22-03433-7 manufactured by Pan Air Electronics, Division of Electronic Equipment Engineering, Inc., Dallas, Texas and designated as their part number JA-IOD.

B. Physical Description (see Figure 1).

(1) The service interphone jack box consists of two major components: The box proper and the base. These units are installed at various locations in the airframe.

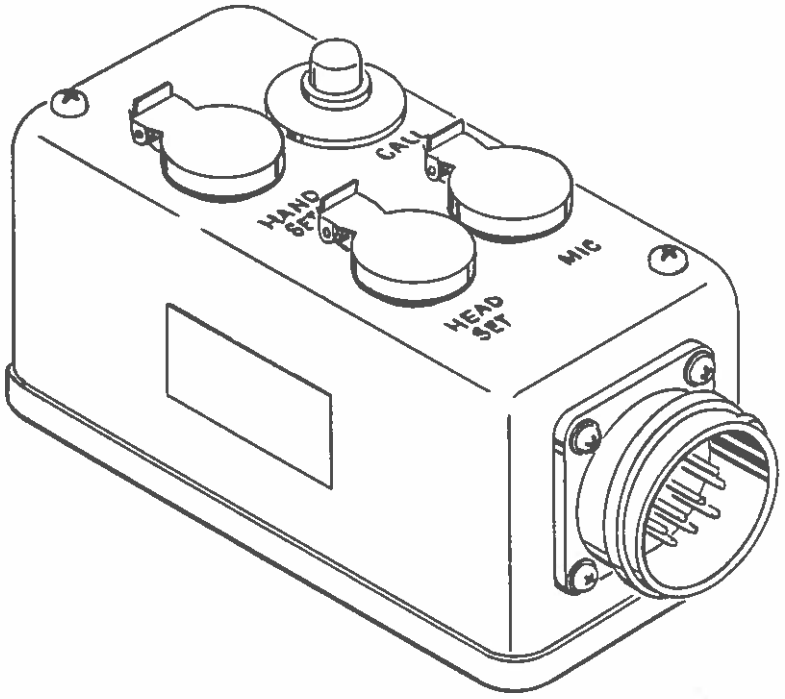
C. Leading Particulars.

Overall height	2-3/4 inches
Overall width	2-1/8 inches
Overall depth	4-3/4 inches
Total weight	0.5 pounds

D. Operation.

(1) The service interphone jack box provides the electrical connectors for interphone service between flight crews and ground or other personnel for the proper coordination of operational and service functions. Jacks are provided for headset, handset and microphone. A call button is also provided.

(2) Employ the service interphone jack box plug in the appropriate associated equipment, and operate it in accordance with the instructions covered in the section of the manual pertaining to its operation. To call another station push the call button.



Service Interphone Jack Box
Figure 1

INTRODUCTION

1. Overhaul Manual - General

This Overhaul Manual has been prepared to the requirements of Air Transport Association of America, Specification for Manufacturers' Technical Data (ATA 100), dated 1 June 1956, as revised 1 May 1958. Chapter-section units have been prepared under cognizance of the equipment manufacturer and collated for inclusion in this Model 30 Overhaul Manual by Technical Publications, GENERAL DYNAMICS/CONVAIR, San Diego, California.

This manual is made up of individual chapter-section-units, each containing complete sequenced step-by-step overhaul procedures applicable to a particular complete assembly. The overhaul procedures herein are designed for use by the overhaul shop mechanic with the assembly removed from the airplane. If a partial overhaul, or the overhaul of only an individual sub-assembly of any assembly should become necessary, comply with the applicable portions of these overhaul instructions. Partial overhauls of an assembly, depending upon the sub-assembly affected, may be performed in some instances, without removing the entire assembly from the airplane. A partial overhaul should not be accomplished as a substitute for accomplishment of overhaul of a complete assembly. Full compliance with the overhaul instructions in this manual will insure that each assembly overhauled is properly restored to a serviceable condition and ready for reuse.

Information relative to flight, operation, structural repair of the airframe, airplane wiring diagrams, maintenance, and airplane assembly part numbers can be found in the following publications:

Model 30 Flight Manual
Model 30 Operations Manual
Model 30 Maintenance Manual
Model 30 Structural Repair Manual
Model 30 Wiring Diagram Manual
Model 30 Illustrated Parts Catalog

A. Chapter and Page Numbering System.

Each chapter-section-unit uses a conventional three-dash numbering system: The first number designates the system/chapter, the second the sub-system/section, and the third the unit/subject. In small chapter-section-units, with the exception of the Illustrated Parts Catalog (IPC) sub-section, several sub-section headings of overhaul data may be presented on one page; the page numbers begin with Page 1 and are numbered consecutively throughout. In the large chapter-section-units all sub-sections are numbered in accordance with ATA Specification 100 assigned page number blocks, with the exception of the IPC sub-section. The IPC sub-section pages are numbered IPC Page 1 and on in all chapter-section-units.

B. Indexing.

Each chapter division is prefaced by a Table of Contents which lists the number, title and assembly part number of each chapter-section-unit contained therein.

C. List of Effective Pages.

A List of Effective Pages precedes each chapter-section-unit to provide a listing of the pages applicable to that particular chapter-section-unit.

2. Overhaul Manual Chapter-Section-Unit Contents

The contents of each chapter-section-unit are arranged in logical overhaul sequence as follows:

Sub-Section Paragraph No.	Title
1.	Description and Operation
2.	Disassembly
3.	Cleaning
4.	Inspection
5.	Repair
6.	Assembly
7.	Fits and Clearances
8.	Testing
9.	Trouble Shooting
10.	Storage Instructions
11.	Special Tools, Fixtures and Equipment
	Illustrated Parts Catalog

A. Illustrated Parts Catalog (IPC)

The IPC sub-section contains a group assembly parts list, exploded view illustrations of the assembly, and a numerical parts list INDEX at the beginning of the IPC sub-section if the group assembly parts list exceeds two pages. Both the numerical INDEX and group assembly parts lists reference the IPC figure and index number of each part. IPC sub-section pages and figures are numbered consecutively and are preceded by the letters IPC.

The group assembly parts list is arranged in order of disassembly. The figure and index number references appear in a column to the left of the part number and the name of the part or assembly to the right of the part number. The group assembly parts lists always follow the applicable IPC figure, either below it or on the following opposite pages. In some cases there will be more than one parts list page per figure.

The numbers in the PART NUMBER column fall into three categories: Convair part numbers, vendor part numbers, or standard part numbers. Parts which have been manufactured by vendors to Convair specification control drawings are listed by their vendor part number in the PART NUMBER column: The nomenclature of these items is followed by MFR TO SPEC CONT XX-XXXXX (Convair Drawing Number). When vendor parts are altered by Convair, a Convair part number is assigned and they are listed by the Convair number in the PART NUMBER column. In such cases the nomenclature of the part is followed by ALTERED FROM ..... (vendor part number).

Whenever a standard or vendor part has been assigned a Convair ten digit number (a form of specification control drawing) this ten digit number XX-XXXXX-XXX follows the nomenclature: Example - Convair 98-76543-021. Part numbers preceded by the letter Q are Convair standard parts.

A vendor code number for all vendor parts follows the Convair specification control drawing number in the nomenclature column. A Master Vendor Code Number List which lists the vendors' code numbers, names, and addresses is included in paragraph 3. The letter P following the vendor code number indicates that the part is Convair proprietary or that Convair has the sales rights.

In the nomenclature column the name of the part or assembly is arranged so that the identifying noun or key words are at the first part of the description. Similar left-hand and right-hand assemblies are broken down together and the quantity of detail parts listed is for one next higher assembly only. A detail used only on the left-hand or right-hand side of its next assembly has LH or RH respectively at the end of the nomenclature. A part used on only one side of the next assembly, that has no comparable opposite hand part has the phrase USED ON LH/RH SIDE/ASSEMBLY ONLY normally following the nomenclature. When an assembly or installation is modified, the phrase "MODIFIED BY XX-XXXXX (modification drawing number)" follows the nomenclature. When alternate parts are listed they fall into one of the following two categories; when the alternate part and the production part are interchangeable, that is, either may replace the other, the phrase "ALT INTCHG WITH XX-XXXXX (production part number)" follows the nomenclature of the alternate part. When the alternate part is a replacement part, that is, the alternate part may replace the production part

but the production part may not replace the alternate part, the phrase "ALT FOR XX-XXXXX (production part number)" follows the nomenclature of the alternate part. In both cases the quantity per assembly for the alternate part is shown as REF. The relationship of the group assembly parts list to the next higher assembly (NHA) is maintained by a cross reference note "FOR NHA SEE FIG ...." following the nomenclature of the top assembly. See figure on opposite page for an explanation of the indentation indexing used in the nomenclature column.

Other symbols used are as follows:

AR -As required. Indicates that an indefinite quantity is required.

REF -Reference. Indicates parts which have been listed previously.

----*---- -Designates the end of each group of attaching parts.

P -CONVAIR proprietary or CONVAIR sales rights.

R -Revision

IPC -Abbreviation to designate the Illustrated Parts Catalog sub-sections of all overhaul manuals.

The IPC sub-section illustrations are exploded views of the subject assembly or a portion thereof. Each detail is carefully illustrated to show its true configuration. A view of the completed assembly is provided on each illustration to show the location of each part in relation to the completed assembly. When left-hand and right-hand assemblies are broken down together, only the left-hand parts are illustrated unless it is desirable for clarity to illustrate the right-hand parts.

USAGE CODE: Entries in the FROM and TO columns for a particular item stipulate inclusive customer airplanes. A number in the "FROM" column only, indicates the particular item is applicable to that and subsequent airplanes. If a letter is shown in the FROM column, an explanatory footnote will appear at the bottom of the IPC parts list page.

The Model 30 drag reduction program projects specific structural, mechanical, and electrical changes that are scheduled for incorporation on all Model 30 airplanes to improve performance. Two group numbers have been assigned to designate applicability between those airplanes which have or have not been modified for drag reduction, as follows:

GROUP I: denotes Model 30 airplanes BEFORE incorporation of drag reduction modification.

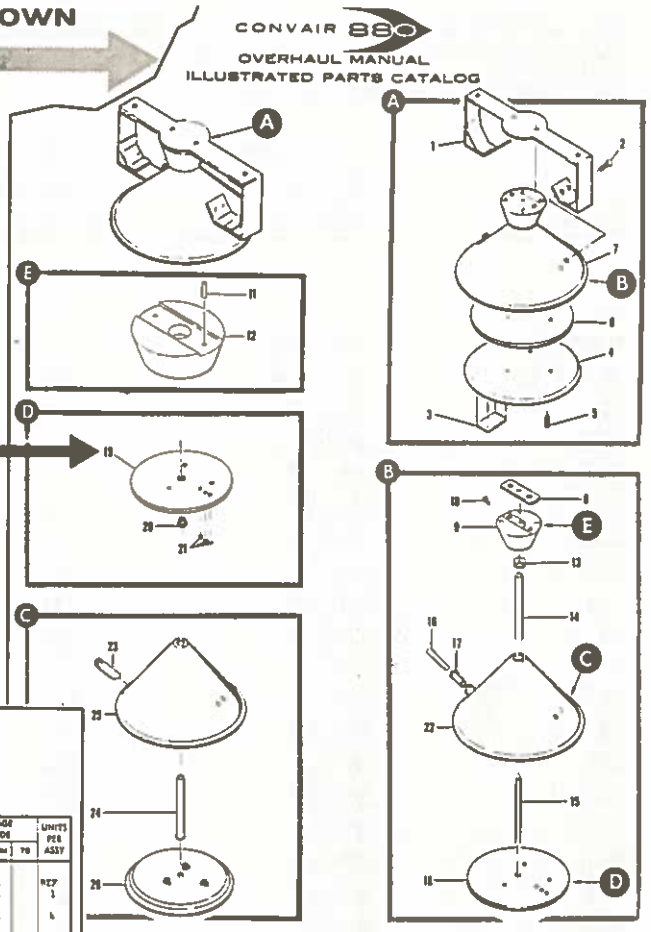
GROUP II: denotes Group I airplanes AFTER modification, and those airplanes DELIVERED with modification. Overhaul chapter-section-units covering part numbers installed during the drag reduction modification, contain specific reference to "Group II Airplanes," in "USAGE CODE" column of IPC parts list.

METHOD OF ASSEMBLY PARTS BREAKDOWN (TYPICAL) ● ● ●

EACH PARTS LIST IS BROKEN DOWN INTO ● ● ●

Assemblies, sub-assemblies, sub-sub assemblies, detail parts and attaching parts. The order in which the items are listed and the identification of the description normally indicates the proper sequence of disassembly/assembly.

PARTS ARE IDENTIFIED BY INDEX NUMBERS



VHF Antenna Assembly - Flush Type
IPC Figure 1
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A-2

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE EAST	MIDW	WE	UNITS PER ASSY
1	23-30513	ANTENNA ASSEMBLY, VHF COMMUNICATION FLUSH TYPE		1		REF
- 1	23-30509	. CAP, VHF, ANTENNA		1		1
		. ATTACHING PARTS				
- 2	NAS623-3-1	. . SCREW		1		4
		. . ----2----				
- 3	23-30521	. . BACKPLATE		1		1
- 4	23-30512	. . COVER		1		2
		. . ATTACHING PARTS				
- 5	AN515-8R10	. . SCREW		1		3
		. . ----2----				
- 6	23-30517-11	. . DISC, MATCHING CIRCUIT		1		1
- 7	23-30513-13	. . ANTENNA ASSEMBLY, VHF COMMUNICATION		1		1
- 8	23-30507	. . . BAR, FILLER		1		1
- 9	23-30515	. . . SPACER ASSEMBLY, VHF ANTENNA		1		1
		. . . ATTACHING PARTS				
- 10	MS00-3	. . . RIVET, CONVAIR 97-63004-203 -V-0536-		1		4
		. . . ---X----				
- 11	3391-3CX630	. . . INSERT, CONVAIR 95-03003-006 -V-0767-		1		1
- 12	23-30513-7	. . . SPACER, BLADE		1		1
- 13	23-30509-7	. . . INSERT, TEFLON		1		1
- 14	23-30509-13	. . . INSERT, TEFLON		1		1
- 15	23-30513-7	. . COLLECTOR		1		1
- 16	23-30518	. . CONTACT ASSEMBLY, VHF ANTENNA SOLDERED		1		1
- 17	23-30509-9	. . INSERT, TEFLON		1		1
- 18	23-30517-1	. . DISC ASSEMBLY, MATCHING CIRCUIT		1		1
- 19	23-30517-7	. . . DISC		1		1
- 20	5857	. . . EYELET, CONVAIR 95-58009-004 -V-0767-		1		1
- 21	5827	. . . EYELET, CONVAIR 95-58009-003 -V-0767-		1		3
- 22	23-30513-15	. . CORE ASSEMBLY, VHF ANTENNA		1		1
- 23	23-30506-7	. . . CONDUCTOR		1		1
- 24	23-30508-7	. . . SLEEVE		1		1
- 25	23-30510	. . . CORE ASSEMBLY, RIVETED		1		1
- 26	23-30511	. . . FAN ASSEMBLY, RIVETED		1		1

● ● ● breakdown normally a right-hand page

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A-2
22.06.1

23-2-5
IPC Page 3

Indenture ● ● ● normally indicates relationship of the next highest assembly to the end item.

NOMENCLATURE

1 2 3 4 5 6 7

The first column item—the assembly, (end item) or installation—consists of all the items listed; items are properly indented beneath to indicate the correct relationship to the end item.

NOTE: Installations are listed in the overhaul manual Illustrated Parts Breakdown only in Chapter 71-0-1, Power Plant-General, and a few other isolated cases.

● Second column items—assemblies, sub-assemblies, or detail parts—together with the related attaching parts for the assembly/disassembly of the first column item are indented one column to the right as applicable.

NOTE: Each second-column assembly may be broken down into it's own sub-assembly and/or detail parts. These items are indented to the 3rd-column for assembly/disassembly as applicable.

● ● Third column items—detail parts for assembly/disassembly of sub-assemblies—together with the applicable attaching parts, are listed in the third column and are indented to the right as necessary.

● ● ● Fourth column items—sub-assemblies, the related detail parts, and sub-sub-assemblies—are further broken down under the 4th column component items and are indented to the 5th column, if necessary. This process continues until complete breakdown is achieved.

NOTE: The attaching parts follow immediately after the item which they attach, and preceed any component of that item. Attaching parts have the same indentation as the parts they attach. They are captioned "Attaching Parts" and are separated from subsequent listing by the symbol: —x—

Following is a cross-reference tabulation of the airplanes by customer name, registration number, usable on airplane code number, customer model number and manufacturing serial number:

CUSTOMER	AIRPLANE REGISTRATION NUMBER	USABLE ON AIRPLANE CODE NO.	CUSTOMER MODEL NUMBER	MANUFACTURING SERIAL NUMBER
-	-	1	30-5-1	1
-	-	2	30-5-2	2
GARUDA	PK-GJA	3	30-5-3	3
GARUDA	PK-GJB	4	30-5-4	4
AAL	N5605	5	30-5-5	9
AAL	N5606	6	30-5-6	10
AAL	N5607	7	30-5-7	16
AAL	N5608	8	30-5-8	18
AAL	N5609	9	30-5-9	21
AAL	N5610	10	30-5-10	22
AAL	N5611	11	30-5-11	23
AAL	N5612	12	30-5-12	24
AAL	N5613	13	30-5-13	25
AAL	N5614	14	30-5-14	26
AAL	N5615	15	30-5-15	27
AAL	N5616	16	30-5-16	28
AAL	N5617	17	30-5-17	29
AAL	N5618	18	30-5-18	30
AAL	N5619	19	30-5-19	31
AAL	N5620	20	30-5-20	32
AAL	N5601	21	30-5-21	33
AAL	N5602	22	30-5-22	34
AAL	N5603	23	30-5-23	35
AAL	N5604	24	30-5-24	36
GARUDA	PK-GJC	25	30-5-25	37
APSA	OB-OAG	1	30-6-1	5
SWISS	HB-ICF	2	30-6-2	6
SWISS	HB-1CA	3	30-6-3	7
SAS	SE-DAY	4	30-6-4	8
SWISS	HB-1CB	5	30-6-5	11
SWISS	HB-1CC	6	30-6-6	12
SWISS	HB-1CE	7	30-6-7	14
SWISS	HB-1CD	8	30-6-8	15
SAS	SE-DAZ	9	30-6-9	17
VARIG	PP-VJE	1	30-8-1	13
VARIG	PP-VJF	2	30-8-2	19
VARIG	PP-VJG	3	30-8-3	20

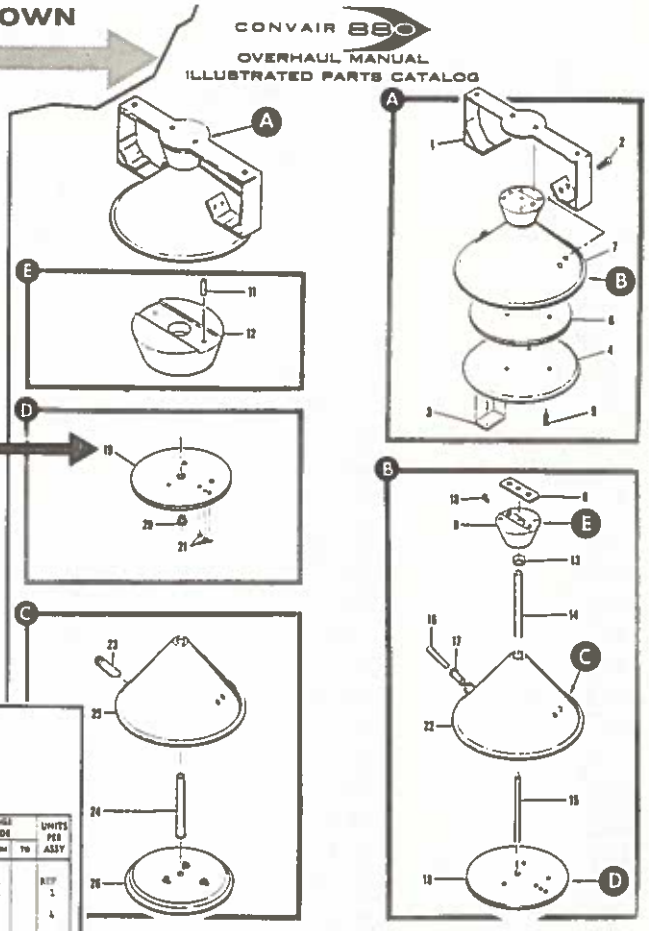
METHOD OF ASSEMBLY PARTS BREAKDOWN (TYPICAL) ● ● ●

EACH PARTS LIST IS BROKEN DOWN INTO ● ● ●

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PARTS ARE IDENTIFIED BY INDEX NUMBERS

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VHF Antenna Assembly - Flush Type
IPC Figure 1
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CONVAIR 880
OVERHAUL MANUAL
ILLUSTRATED PARTS CATALOG

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USABLE CODE CURT	FROM	TO	UNITS PER ASSY
R 1	22-30513	ANTENNA ASSEMBLY, VHF COMMUNICATION FLUSH TYPE		1		REF
- 1	22-30505	. CAP, VHF, ANTENNA		1		1
		ATTACHING PARTS				
- 2	BAB623-3-1	. SCREW		1		4
		----X----				
- 3	22-30521	. BASEPLATE		1		1
- 4	22-30518	. COVER		1		1
		ATTACHING PARTS				
- 5	AN515-6R10	. SCREW		1		9
		----X----				
R - 6	22-30517-11	. DISC, MATCHING CIRCUIT		1		1
R - 7	22-30513-13	. ANTENNA ASSEMBLY, VHF COMMUNICATION		1		1
- 8	22-30507	. . BAR, FILLER		1		1
R - 9	22-30515	. . SPACER ASSEMBLY, VHF ANTENNA				1
		ATTACHING PARTS				
R - 10	FH00-3	. . RIVET, CONVAIR 97-63004-203 -Y1[illegible]-		1		4
		----X----				
R - 11	3391-3CH380	. . . INSERT, CONVAIR 95-03003-006 -Y11767-		1		1
- 12	22-30515-7	. . . SPACER, BLOCK		1		1
- 13	22-30509-7	. . . INSERT, TEFLON		1		1
- 14	22-30509-13	. . . INSERT, TEFLON		1		1
- 15	22-30513-7	. . CONDUCTOR		1		1
R - 16	22-30516	. . CONTACT ASSEMBLY, VHF ANTENNA SOLDERED		1		1
- 17	22-30509-9	. . . INSERT, TEFLON		1		1
R - 18	22-30517-1	. . DISC ASSEMBLY, MATCHING CIRCUIT		1		1
R - 19	22-30517-7	. . . DISC		1		1
R - 20	8287	. . . EYELET, CONVAIR 95-58005-004 -Y61157-		1		1
R - 21	8287	. . . EYELET, CONVAIR 95-58005-003 -Y61157-		1		3
R - 22	22-30513-11	. . CORE ASSEMBLY, VHF ANTENNA		1		1
R - 23	22-30508-7	. . . CONNECTOR		1		1
R - 24	22-30508-7	. . . SLEEVE		1		1
R - 25	22-30510	. . . CORE ASSEMBLY, RIVETED		1		1
R - 26	22-30511	. . . PAN ASSEMBLY, RIVETED		1		1

● ● ● breakdown normally a right-hand page

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A-2
22.06.1

23-2-5
IPC Page 3

Indenture ● ● ● normally indicates relationship of the next highest assembly to the end item.

NOMENCLATURE

1 2 3 4 5 6 7

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Following is a cross-reference tabulation of the airplanes by customer name, registration number, usable on airplane code number, customer model number and manufacturing serial number:

CUSTOMER	AIRPLANE REGISTRATION NUMBER	USABLE ON AIRPLANE CODE NO.	CUSTOMER MODEL NUMBER	MANUFACTURING SERIAL NUMBER
CAC	-	1	30-5-1	1
CAC	-	2	30-5-2	2
GARUDA	PK-GJA	3	30-5-3	3
GARUDA	PK-GJB	4	30-5-4	4
AAL	N5605	5	30-5-5	9
AAL	N5606	6	30-5-6	10
AAL	N5607	7	30-5-7	16
AAL	N5608	8	30-5-8	18
AAL	N5609	9	30-5-9	21
AAL	N5610	10	30-5-10	22
AAL	N5611	11	30-5-11	23
AAL	N5612	12	30-5-12	24
AAL	N5613	13	30-5-13	25
AAL	N5614	14	30-5-14	26
AAL	N5615	15	30-5-15	27
AAL	N5616	16	30-5-16	28
AAL	N5617	17	30-5-17	29
AAL	N5618	18	30-5-18	30
AAL	N5619	19	30-5-19	31
AAL	N5620	20	30-5-20	32
AAL	N5601	21	30-5-21	33
AAL	N5602	22	30-5-22	34
AAL	N5603	23	30-5-23	35
AAL	N5604	24	30-5-24	36
GARUDA	PK-GJC	25	30-5-25	37
-	-	1	30-6-1	5
-	-	2	30-6-2	6
SWISS	HB-1CA	3	30-6-3	7
SAS	SE-DAY	4	30-6-4	8
SWISS	HB-1CB	5	30-6-5	11
SWISS	HB-1CC	6	30-6-6	12
SWISS	HB-1CE	7	30-6-7	14
SWISS	HB-1CD	8	30-6-8	15
SAS	SE-DAZ	9	30-6-9	17
VARIG	PP-VJE	1	30-8-1	13
VARIG	PP-VJF	2	30-8-2	19
VARIG	PP-VJG	3	30-8-3	20

3. Vendor Code Numbers

A list of Vendors, who have or are currently manufacturing equipment covered in this overhaul manual, is provided on the following pages. Each vendor name and address is listed adjacent to the applicable Vendor code number (when available) and the list is arranged in numerical order by vendor code number. The Vendor code numbers which are assigned to a vendor by the U.S. Government and listed in this manual, are obtained from the Federal Supply Code for Manufacturers (Cataloging Handbook H4), which may be purchased from The Superintendent of Documents, U. S. Government Printing Office, Washington 25, D.C., U.S.A. The parts lists contained in the Illustrated Parts Catalog (IPC) sub-section of the chapter-section-units comprising this overhaul manual, list the current vendor code number, as applicable. When a vendor code number is listed in this manual, the following list may be referred to for determining vendor name and address.

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES

	Pasadena Equipment & Supply Company Pasadena, California
	Premmco Incorporated Los Angeles, California
-V00163-	Reid Metal Products 2021 N. Lincoln Street Burbank, California
-V00194-	Walsco Electronics Corp. Los Angeles, California
-V00266-	Acme Steel Company Chicago, Illinois
-V00307-	Power Engineering Company Torrance, California
-V00624-	Aeroquip Corporation Jackson, Michigan
-V00779-	Aircraft Marine Products, Incorporated Harrisburg, Pennsylvania
-V00986-	Joclin Manufacturing Co. North Haven, Connecticut
-V02217-	Zep Aero 109-116 Sheldon St. El Segundo, California
-V02660-	American Phenolic Corp. Chicago, Illinois
-V02777-	Hopkins Engineering Co. San Fernando, California
-V03818-	Parker Seal Company Los Angeles, California
-V04148-	Fortin Plastics 14811 Keswick Street Van Nuys, California
-V04211-	Coastal Manufacturing Co. 217 Rose Ave. Venice, California
-V04811-	Precision Coil Spring Co. El Monte, California
-V04970-	Pan Air Electronics Corp. 1120 W. Magnolia Blvd. Burbank, California

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES (CONT)

-V05476- Firestone Tire & Rubber Co.
Fuel Cell Division
2525-Firestone Blvd.
Los Angeles, California

-V05695- Master Pneumatics
Detroit,
Michigan

-V06139- Canadian Applied Research
Limited
1500 O'Connor Drive
Toronto 16, Ontario, Canada

-V06239- A.U. Stone & Company, Inc.
New York,
New York

-V06840- Bendix Aviation Corporation
Bendix Scintilla Div.
Sidney, New York

-V07056- Besler Corporation
4053 Harian St.
Emeryville, California

-V07199- U.S. Radium Corp.
5420 N. Vineland Ave.
N. Hollywood, California

-V07589- Argonne Electronic Mfg.
Company
Jamaica, New York

-V08018- Borg-Warner Corporation
Spring Division
Bellwood, Illinois

-V08785 Ann Arbor Bearing & Mfg.Co.
Ann Arbor,
Michigan

-V09922- Burndy Engineering Co.
Norwalk,
Connecticut

-V13002- Cleveland Pneumatic Tool
Company, Division of
Cleveland Pneumatic
Ind., Incorporated
3781 E. 77th Street
Cleveland 5, Ohio

-V17419- The Deutsch Company
Los Angeles,
California

-V20615- Nylock Corporation
Paramus,
New Jersey

-V21335- Fafnir Bearing Co.
New Britain,
Connecticut

-V24446- General Electric Co.
Schenectady,
New York

-V24930- Gilfillan Brothers
1815 Venice Blvd.
Los Angeles 6, California

-V24981- Gits Brothers Mfg. Co.
Chicago,
Illinois

-V29666- Huck Manufacturing Co.
Detroit,
Michigan

-V38443- Marlin - Rockwell Corp.
Jamestown,
New York

-V39661- Menasco Mfg. Company
805 S. San Fernando Blvd.
Burbank, California

-V40228- Micro Switch Division
Honeywell Regulator Co.
Freeport, Illinois

-V40266- Micro-Precision Division
Micromatic Hone Corporation
Detroit, Michigan

-V40920- Miniature Precision Bearings
Keene,
New Hampshire

-V43334- New Departure Division
General Motors Corporation
Bristol, Connecticut

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES (CONT)

-V43991-	Norma Hoffman Bearings Corporation Stamford, Connecticut
-V45402-	Pacific Scientific Co. Los Angeles, California
-V48170-	H.K. Porter Co., Inc. Pittsburgh, Pennsylvania
-V50625-	Revere Corporation of America Wallingford, Connecticut
-V51116-	Robinson Aviation, Inc. Teterboro, New Jersey
-V56878-	Standard Pressed Steel Company Jenkintown, Pennsylvania
-V59875-	Thompson Ramo Wooldridge, Inc. 8354 Wilcox Avenue Bell, California
-V60038	The Timkin Roller Bearing Company Canton, Ohio
-V60380-	The Torrington Co. Torrington, Connecticut
-V61463-	United States Rubber Co. New York, New York
-V61864-	United Carr Fastener Corporation Boston, Massachusetts
-V62793-	Vard, Incorporated 2981 E. Colorado Street Pasadena, California
-V62983-	Vickers, Incorporated Detroit, Michigan
-V70203-	Aircraft Mechanics, Inc. 3300 N. Nevada Ave. Colorado Springs, Colorado
-V70210-	Airesearch Mfg. Company Los Angeles, California
-V70270-	Stewart Warner Corporation Division of Alemite Chicago, Illinois
-V70276-	Allen Manufacturing Co. Hartford, Connecticut
-V71124-	Wm. Brand Company Willimantic, Connecticut
-V71286-	Camloc Fastener Corp. Paramus, New Jersey
-V71468-	Cannon Electric Co. Los Angeles, California
-V71643-	Connecticut Hard Rubber Co. New Haven, Connecticut
-V71984-	Dow-Corning Corporation Midland, Michigan
-V71985-	Dow Elco, Incorporated 1313 W. Olympic Blvd. Montebello, California
-V72152-	Electronic Specialty Co. 5121 San Fernando Road Los Angeles 39, California
-V72699-	General Instrument Company Newark, New Jersey
-V72962-	Elastic Stop Nut Corporation of America Union, New Jersey

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES (CONT)

-V73030-	Hamilton Std. Propeller Div. United Aircraft Corp. East Hartford, Connecticut
-V73302-	Huntington Precision Prod. Corporation Div. Adel Precision Products Corp. Huntington, W. Virginia
-V73680-	Garlock Packing Company Palymra, New York
-V75165-	Johns-Manville Corporation New York, New York
-V75237-	Kaynar Manufacturing Co. Riviera, California
-V75345-	Kirkhill Rubber Company Los Angeles, California
-V75361-	Koehler Aircraft Prod. Co. Kayton, Ohio
-V75397-	Korry Manufacturing Co. South Seattle, Washington
-V76680-	National Motor Bearing Company, Incorporated Redwood City, California
-V77308-	Plastic & Rubber Products Los Angeles, California
-V77932-	Simmonds Aerocessories, Incorporated Tarrytown, New York
-V78118-	Split Ball Bearing Corp. Lebanon, New Hampshire
-V78553-	Tinnerman Products, Inc. Cleveland, Ohio
-V78570-	Titeflex, Incorporated Springfield, Massachusetts
-V78655-	Suprenant Mfg. Company Boston, Massachusetts
-V78710-	Teleflex, Incorporated P.O. Box 218 347 W. Walnut Street North Wales, Pennsylvania
-V78947-	Ucinite Company Newtonville, Massachusetts
-V79136-	Waldes Koh-I-Noor, Inc. Long Island City, New York
-V79150-	Victor Manufacturing & Gasket Company Chicago, Illinois
-V79294-	Western Hydraulics, Ltd., North Hollywood, California
-V79326-	E.B. Wiggins Oil Tool Co. Los Angeles, California
-V79470-	Weatherhead Company Cleveland, Ohio
-V80201-	The Chicago Rawhide Mfg.Co. Chicago, Illinois
-V80208-	United States Gauges Div. American Machine & Metals Incorporated New York, New York
-V80234-	Vapor Heating Corp. Chicago, Illinois

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES (CONT)

-V80378-	Chance Vought Aircraft, Inc. P.O. Box 5907 Dallas 22, Texas
-V80477-	Adams Rite Mfg. Company 540 W. Chevy Chase Dr. Glendale 4, California
-V80523-	American Chain & Cable Co. Automotive & Aircraft Div. Adrain, Michigan
-V80756-	Spiralox Division The Ramsey Corporation St. Louis, Missouri
-V81039-	Airborne Accessories Corp. 1414 Chestnut Hillside, New Jersey
-V81629-	Halfo Bearing Division 10711 Chandler Blvd. N. Hollywood, California
-V81823-	West Coast Electrical Manufacturing Co. Los Angeles, California
-V81825-	Aero Instrument Co. Glendale & N. Hollywood California
-V81892-	Hydro-Aire Inc. Burbank, California
-V81893-	General Electric Company Lynn River Works Lynn, Massachusetts
-V81896-	Airite Products, Inc. 3615 E. Olympic Blvd. Los Angeles 23, California
-V81904-	Clover Industries Inc. Tonawanda, New York
-V82106-	Bertea Products 1450 N. Lake Street Pasadena 6, California
-V82373-	Whitaker Cable Corporation Philadelphia, Pennsylvania
-V82402-	Western Gear Corporation P.O. Box 192 Lynwood, California
-V82833-	Hansen-Lynn Co., Inc. 800 S. Flower St. Burbank, California
-V83014-	Hartwell Aviation Supply Company 9035 Venice Blvd. Los Angeles 34, California
-V83259-	Franklin C. Wolf Co. Inc. Beverly Hills & Culver City, California
-V83324-	Rosan, Incorporated Newport Beach, California
-V83330-	Herman H. Smith Company Brooklyn, New York
-V83512-	Nylok Corporation New York, New York
-V83549-	Langley Corporation 310 Euclid Ave. San Diego 12, California
-V83930-	Adel Division General Metals Corp. Huntington, W. Virginia
-V84256-	Aviation Development, Inc. Burbank, California
-V84971-	T.A. Manufacturing Corp. Los Angeles, California

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES (CONT)

-V89193- United Aircraft Products Incorporated
Los Angeles, California

-V91207- Gar Precision Parts, Inc.
190 Henry Street
Stamford, Connecticut

-V91422- Formsprag Corporation
Warren,
Michigan

-V91767- Heil-Coil Corporation
Danbury,
Connecticut

-V92065- Redco Tool Division
Red Lion,
Pennsylvania

-V92799- Aeroduct, Incorporated
South Gate,
California

-V92824- Weber Aircraft Corp.
2820 Ontario St.
Burbank, California

-V93469- Kollsman Instrument Corp.
Western Division
Glendale, California

-V93835- National Waterlift Co., Incorporated
2220 Palmer Ave.
Kalamazoo, Michigan

-V94641- Ronson Hydraulic Units Corporation
1313 Lincoln Ave.
Pasadena 3, California

-V94791- General Electric
Flight Propulsion Lab.
1 Jimson Road
Evendale, Ohio

-V96124- Accessory Products Co.
Whittier,
California

-V96142- Flexonics Corporation
3324 Delhi Road
Santa Ana, California

-V96182- Master Specialties Co.
956 E. 108th St.
Los Angeles, California

-V96215- Carl Drescher
1951 N. Ontario St.
Burbank, California

-V96655- California Plastecks, Inc.
225 E. 4th St.
Los Angeles 13, California

-V96679- Albert Trostel Packing Limited
Lake Geneva, Wisconsin

-V97484- Technical Development Corp.
Glenolden,
Pennsylvania

-V97532- National Seating Company
555 Park Ave. East
Mansfield, Ohio
Exclusive Agent:
George B. Cross Company
624 S. Michigan Ave.
Chicago 5, Illinois

-V97613- Kahr Bearing Company
Burbank,
California

-V97820- W.S. Shamban & Company
Culver City,
California

-V97978- D.W. Price
Los Angeles,
California

-V98140- Airmark Plastic Corporation
5524 Vineland
N. Hollywood, California

-V98505- Hydra Electric
Burbank,
California

MASTER VENDOR CODE NUMBER LIST AND ADDRESSES (CONT)

-V98625-	Marman Products Company Los Angeles, California
-V99020-	B.F. Goodrich Company 5400 E. Olympic Blvd. Los Angeles, California
-V99193-	Airesearch Mfg. of Arizona Phoenix, Arizona
-V99232-	Schroeder Mfg., Inc. Long Beach, California
-V99473-	Stellar Hydraulic Co., Inc. 9017 San Fernando Rd. Sun Valley, California

Chapter 13

STANDARD PRACTICES - REPAIR OF PNEUMATIC DUCTING

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Chapter 13

STANDARD PRACTICES - REPAIR OF PNEUMATIC DUCTING

1. General

A. The purpose of this section is to present procedures for the repair of damaged pneumatic ducting.

(See Figure 401.) Stainless steel ducts are used in the engine inlet anti-ice and windshield rainclearing systems, for the engine and bleed air manifolds, and for the ducts to the air conditioning - pressurization system. The ducts are fabricated of stainless steel type 321, 347, or type 19-9DL, and in most cases contain one or more bellows to allow for expansion. Most ducts are covered with removable insulation. The normal operating pressure of the bleed air ducts is between 35 and 45 psig. The ducts are designed to withstand full engine pressure and temperature, 237 psig at 867 degrees F.

The wing anti-icing ducts are made of titanium or stainless steel and operate at a normal pressure of approximately 13 psig at 800 degrees F; they are designed to withstand 40 psig at 867 degrees F.

Plastic, fiberglas or aluminum alloy ducts are used in the air distribution system to convey air from the air conditioning packages to the crew and passenger compartments, and to the electrical and electronic compartments.

2. Pneumatic Ducting

A. Stainless steel ducts.

(1) General.

(a) Most of the duct assemblies used in the bleed air system are constructed of thin wall 19-9DL stainless steel. Stainless steel duct sections used in the bleed air system contain one or more bellows assemblies, to allow for expansion of the duct. The bellows are constructed of convoluted, multiple-ply, thin gage stainless steel; the thickness of each ply on some parts is only 0.004 inch. The outer ply is vented to atmosphere and the inner plies are sealed. Cracks or holes in the inner plies of bellows assemblies are inaccessible for repair.

CAUTION: WELD REPAIR ON THE BELLOWS ASSEMBLY IS NOT RECOMMENDED AS IT MIGHT RESULT IN HIGHER STRESSES IN THE REST OF THE CONVOLTIONS, AND CAUSE EARLY FAILURE.

(2) Cleaning.

(a) Prior to inspection, clean duct with a clean cloth moistened with cleaning solvent to Federal Specification P-D-680, or equivalent. Dry with filtered compressed air or a clean lint-free cloth.

WARNING: USE SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

CAUTION: DO NOT ALLOW SOLVENT TO ENTER VENT HOLES IN BELLOWS ASSEMBLY.

(b) Before and after welding, clean repair area with a stiff wire brush or other suitable mechanical means. The inside of duct assemblies must be cleaned of filings, metal chips, and other foreign matter.

CAUTION: DO NOT USE AN ACID DIP FOR CLEANING DUCTS.

(3) Allowable damage limits.

(a) Scratches.

Scratches in ducts less than one duct radius in length and less than ten percent of the wall thickness in depth, may be polished out with crocus cloth. Scratches exceeding one duct radius in length, or exceeding ten percent of the wall thickness in depth may be repaired by welding; refer to paragraph 2.A.(7)(b).

Replace bellows if scratches in bellows section pierce the outer ply or extend a length of 1.5 times the depth of convolution.

Scratches on flanges or flange face not exceeding 0.005 inch in depth may be removed by using crocus cloth. Flange face must be flat within 0.007 inch Total Indicator Reading (T.I.R.)

(b) Smooth dents.

Small smooth dents on the bellows convolutions may be ignored unless microscopic examination shows signs of a fracture, or shape of indentation has caused adjacent convolutions to touch. In either case, the bellows must be replaced. Dents in straight walled ducting must not exceed five percent of the duct diameter. Dents in drop hammer-formed half elbows must not exceed two percent of the duct diameter.

Small smooth dents on the bellows convolutions may be ignored unless microscopic examination shows signs of a fracture, or shape of indentation has caused adjacent convolutions to touch. In either case the bellows must be replaced.

(c) Creased dents.

Sharp creases in ducts must be treated as cracks; refer to paragraph 2.A.(3)(d).

Dents with sharp creases are not acceptable in bellows. Replace bellows.

(d) Cracks (see Figure 402).

Longitudinal cracks in ducts, not exceeding 0.025 inch wide and one duct diameter long may be repaired by welding. Circumferential cracks in ducts, not exceeding 0.025 inch wide and one-quarter duct diameter long may be repaired by welding; refer to paragraph 2.A.(7)(d).

Cracks in the bellows section are non-repairable. Replace bellows.

Replace flanges that are cracked.

(e) Cracked welds.

A crack in the weld of a doubler or gusset may be repaired by welding; refer to paragraph 2.A.(7)(e).

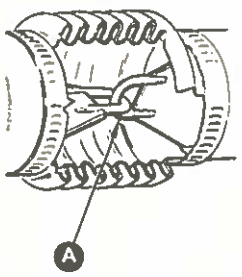
Cracks not exceeding one inch in length in the joint weld of drop hammer-formed parts may be repaired by welding; refer to paragraph 2.A.(7)(f).

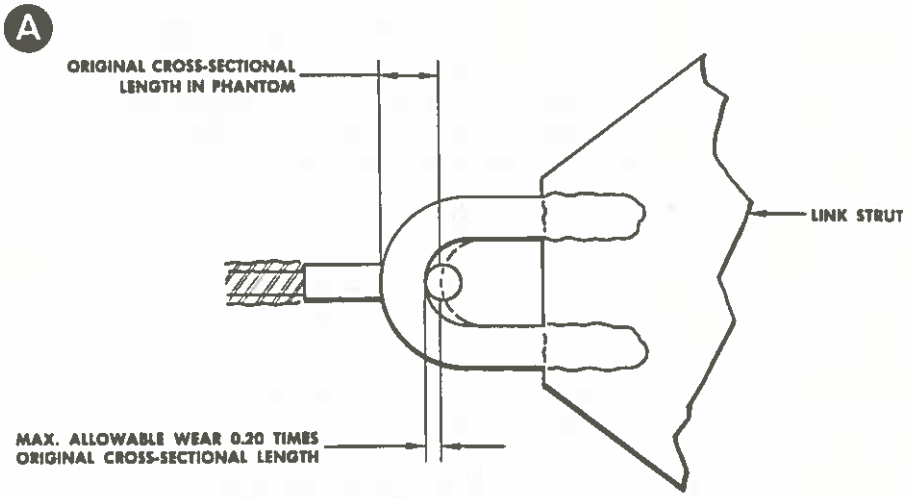
Cracks exceeding one inch in length in the seam weld of drop hammer-formed parts may be repaired by doubler; refer to paragraph 2.A.(8)(b).

(f) Holes.

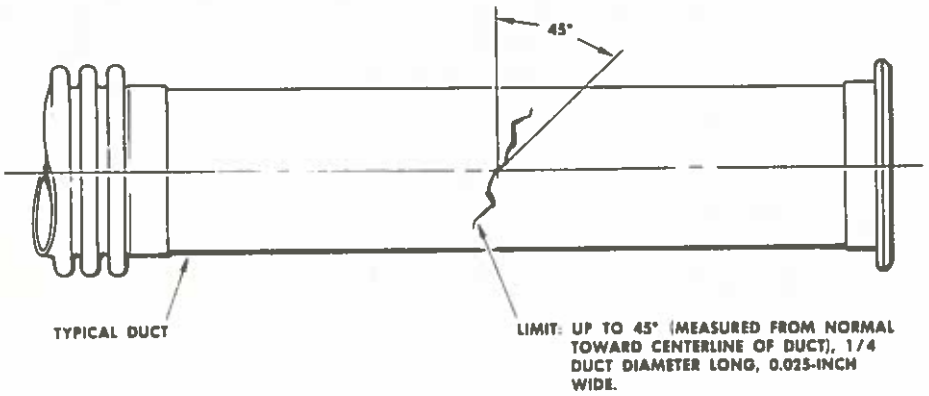
Holes or tears in duct sections require doubler repair; refer to paragraph 2.A.(8), or duct replacement; refer to paragraph 2.A.(9)(a).

Holes or tears in bellows are non-repairable. Replace bellows; refer to paragraph 2.A.(9)(b).

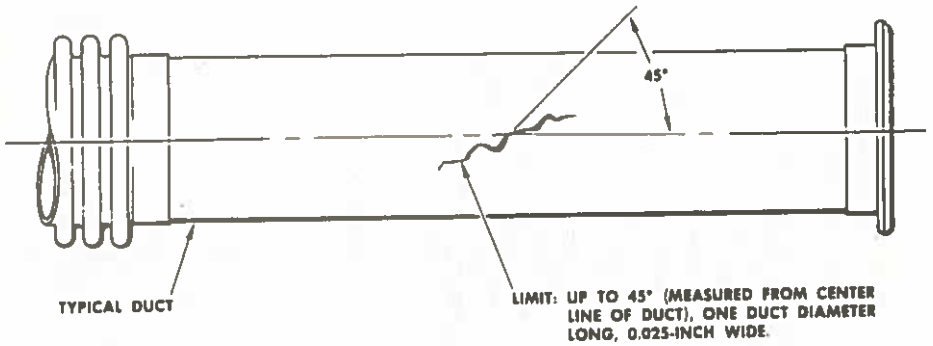




BELLOWS WEAR



CIRCUMFERENTIAL CRACK



LONGITUDINAL CRACK

22.04.13.5.8.002

CONVAIR
JET AIRLINER
OVERHAUL MANUAL

STANDARD PRACTICES - REPAIR OF PNEUMATIC DUCTING

ATA NO. 13-5-8

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS

Applicable to Models 22-1, 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-3, 22(M)-21-4, 22(M)-22, 30-5, 30-6, and 30-8

Mar. 31/65

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	Blank		
13-5-8	401	June 12/62	A-1
*13-5-8	402	Mar. 31/65	A-1
13-5-8	403	June 12/62	A-1
	Blank		
*13-5-8	405	Mar. 31/65	A-1
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*Pages revised, added, or deleted by this revision.

(g) Wear (see Figure 402).

If wear in the tie-bar linkage of a bellows assembly exceeds 0.2 times the original cross-sectional area of the link, the bellows assembly must be replaced.

(4) Inspection.

(a) Visually inspect duct assemblies for tears, scratches, cracks, dents, holes, wear, and distortion.

(b) Inspect all cracked duct welds and suspected crack areas discovered in paragraph (a), using dye penetrant method per Military Specification MIL-I-6866.

(c) Where practicable, inspect for wear of bellows tie-bar links with the aid of a borescope. Refer to paragraph 2.A.(3)(g).

(d) Inspect sealing face of flanges for nicks, scores, scratches, dents, and distortion.

(5) Special tools and equipment.

(a) Weld fixtures. Refer to paragraph 2.C.

(b) Inert gas arc welding equipment.

(c) Bare filler wire, Part No. AISI-347.

(d) Bare filler wire, Part No. 19-9WX.

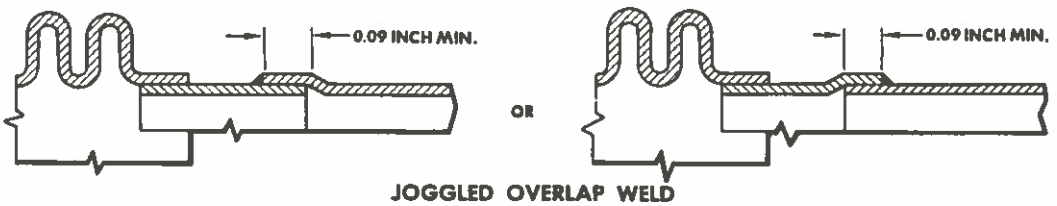
(6) Duct welding.

(a) General.

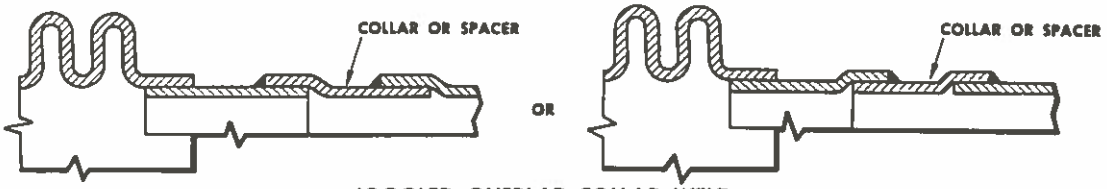
Extensive welding, or replacement of a duct section, flange, or bellows, requires the use of welding fixtures to prevent shrinking or warping of repaired duct assembly. Acetylene welding is not recommended as the excessive heat will distort the metal and, in addition, flux clean-up is required.

Type 19-9DL stainless steel must be in the annealed condition before welding.

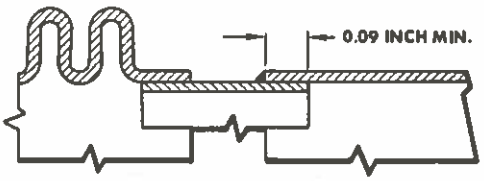
After any weld repairs are carried out on a duct assembly, the welds must be inspected, and the duct assembly proof pressure tested. Refer to paragraph 2.A.(10).



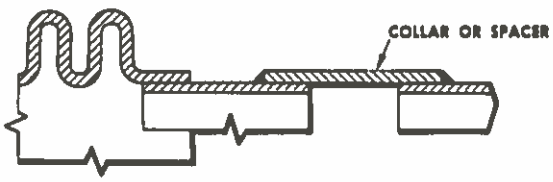
JOGGLED OVERLAP WELD



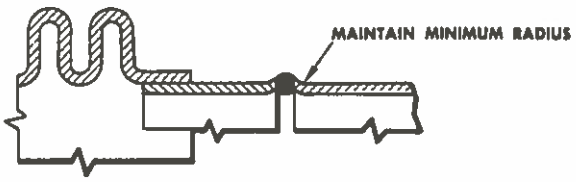
JOGGLED OVERLAP COLLAR WELD



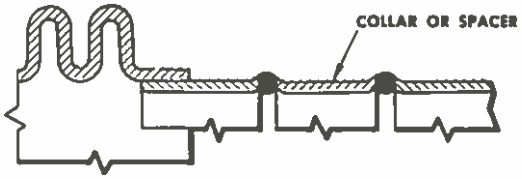
STRAIGHT OVERLAP WELD



STRAIGHT OVERLAP COLLAR WELD



BURN-DOWN FLANGE WELD



BURN-DOWN FLANGE COLLAR WELD

22 06.13.5 8 003

(b) Typical duct welds.

(See Figure 403.) The majority of welds are overlap type. The burn-down flange method is optional (321 or 347 stainless steel only) and should be used only when necessary, because of difficulties encountered in fitting.

(c) Inert gas arc welding of ducts.

Provide adequate protection from oxidation to the underbead side of the weld with an inert atmosphere. Back-up flux may be used, but is not required where the underbead side of the weld can be satisfactorily protected with an inert atmosphere.

When using an inert atmosphere, the minimum flow rate is nine cubic feet per hour for argon, and 13 cubic feet per hour for helium.

The tungsten electrodes should extend no further from the cup than is necessary for visibility. A length of 0.25 to 0.38 inch is recommended as a maximum. When low currents are used, it may be necessary to sharpen the electrodes to a point.

Use minimum heat and ample gas.

(d) Tack welding of ducts.

Tack welding must be used during assembly, to minimize distortion and insure proper alignment of the parts.

Whenever possible, small and neat tack welds should be symmetrically spaced along the joint. Tack welds must be of sufficient size and length to permit ease of subsequent welding, yet insure the parts will be held in alignment without cracking due to expansion and contraction of the first layer of the weld deposit.

All tack welds must be ground to remove slag and scale, and the ends beveled to merge smoothly with the base metal.

If a tack weld is cracked, it must be completely removed.

CAUTION: DO NOT ATTEMPT TO WELD OVER A CRACKED TACK WELD.

(e) Butt welding of ducts.

In a square butt preparation with no root opening, the width of the weld bead must be four times the thickness of the base material.

Penetration of the weld must be 100 percent, as evidenced by the absence of the joint line on the side opposite the weld bead. For butt welds made by welding both sides, the first root pass must be sufficiently penetrated by the second root pass to insure complete fusion through the joint.

(f) Standing edge welding of ducts.

CAUTION: DO NOT ATTEMPT TO TURN A BURN-DOWN FLANGE ON TYPE 19-9DL STAINLESS STEEL DUCTS, AS THE METAL WORK HARDENS AND REQUIRES ANNEALING AFTER FORMING.

To secure a maximum faying surface area, when forming a standing edge, the included angle between the edge to be welded and the surface of the parts must not exceed 92 degrees. The bend radius must not exceed 0.040 inch.

It is recommended that the component parts be tack welded at approximately 0.5-inch intervals along the edge. The tack welds should be located as close to the flange radius as possible, so that the subsequent trimming operation will not remove more than half the effective tack weld area.

Following tack welding, on standing edges, trim edge to produce standing edge heights as specified. (See Figure 404.) Any burrs resulting from the trimming operation must be removed prior to welding.

(7) Duct repair by welding.

(a) General.

Clean damaged duct area as specified in paragraph 2.A.(2)(b).

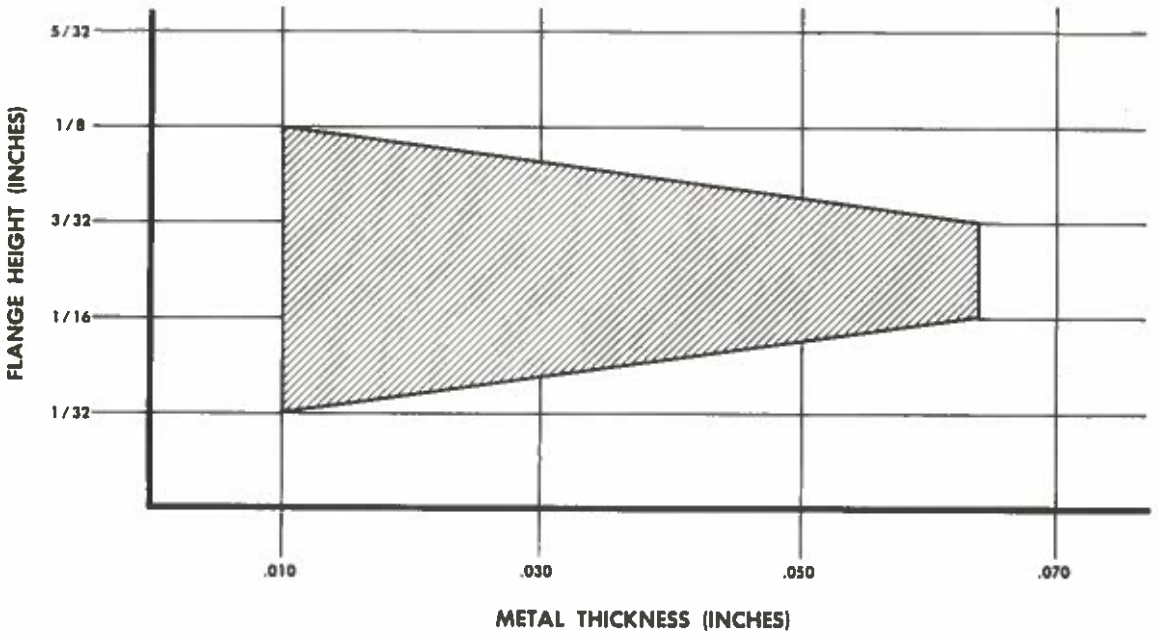
The duct assembly must be placed in a welding fixture for extensive weld repairs close to duct flanges.

Edges to be fusion welded must be free from defects and of a surface smoothness of 250 microinch RMS or less.

(b) Repairing duct scratches.

Scratches in tubular section of duct exceeding limits specified in paragraph 2.A.(3)(a) should be repaired by filling scratch with AISI-347 or 19-9WX filler rod, as applicable, while purging duct with inert gas.

Inspect as specified in paragraph 2.A.(10).



NOTE:
THIS GRAPH PRESENTS THE RECOMMENDED VALUES FOR FLANGE HEIGHT VERSUS METAL THICKNESS FOR STANDING EDGE WELDS OF TYPES 321/347 STAINLESS STEEL ONLY.

22.06.13 5.8.004

(c) Repairing duct creased dents.

Dress dented portion back to normal shape of duct with appropriate hand tools.

Treat crease as a crack and repair as specified in paragraph 2.A.(7)(d).

(d) Repairing duct cracks (see Figure 402).

A crack in the tubular section of duct within the limits described in paragraph 2.A.(3)(d), should be repaired as follows:

1) Clean damaged area.

2) Work crack so that edges butt and cracked area is uniform with duct contour.

3) Stop drill 0.060-inch diameter hole at ends of crack.

4) Preheat crack area around circumference of duct to 800 degrees F.

5) Inert gas arc weld, using AISI-347 or 19-9WX filler rod, as applicable. Start at center of crack and weld to 0.125 inch past stop drill holes while purging duct with inert gas.

6) Inspect as specified in paragraph 2.A.(10).

(e) Repairing duct cracked welds.

A crack in the weld of a doubler or gusset may be repaired as follows:

1) Clean damaged area.

2) Stop drill 0.060-inch diameter hole at each end of crack.

3) Apply a fusion type weld to area while purging duct with inert gas.

4) Inspect as specified in paragraph 2.A.(10).

(f) Repairing duct cracked seam weld.

Cracks not exceeding one inch in length in the seam weld of drop hammer-formed parts may be repaired as follows:

1) Clean damaged area.

2) Stop drill 0.060-inch diameter hole at each end of crack.

3) Grind off old weld in damaged area.

4) Inert gas arc weld, using AISI-347 or 19-9WX filler rod, as applicable. Start at center of crack and weld to 0.125 inch past stop drill holes while purging duct with inert gas.

5) Inspect as specified in paragraph 2.A.(10).

(g) Repair duct cracked boss weld.

A crack in the weld between a boss and a doubler may be repaired as follows:

1) Clean damaged area.

2) Stop drill 0.060-inch diameter hole at each end of crack.

3) Grind off old weld in damaged area.

4) Inert gas arc weld, using AISI-347 or 19-9WX filler rod, as applicable. Start at center of crack and weld to 0.125 inch past stop drill holes, while purging duct with inert gas.

5) Inspect as specified in paragraph 2.A.(10).

(8) Duct repair by doubler.

(a) Cracks (see Figure 405).

Cracks, deep scratches, or dents with sharp creases in ducting may be repaired by doubler as follows:

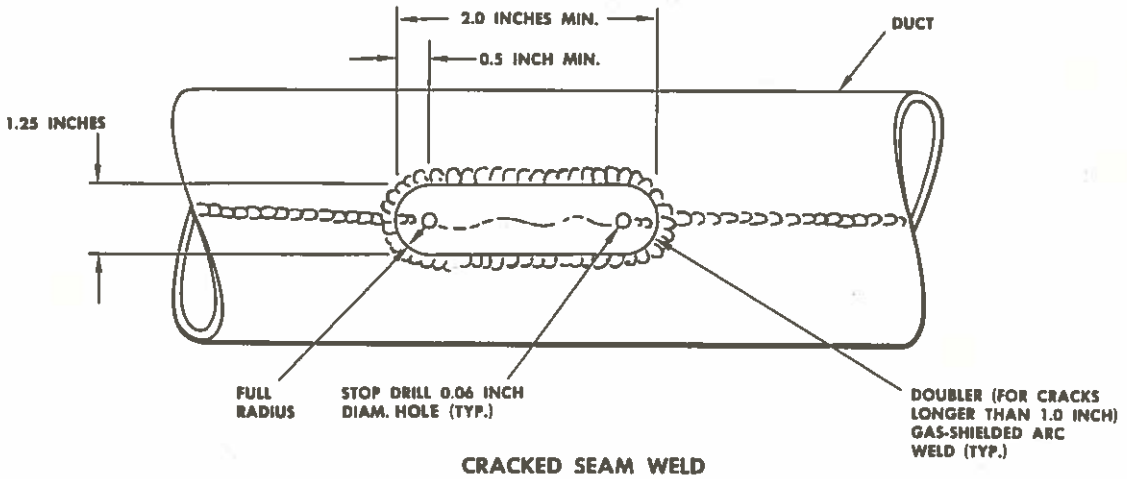
1) Clean damaged area.

2) Stop drill 0.060-inch diameter hole at each end of crack, or crease.

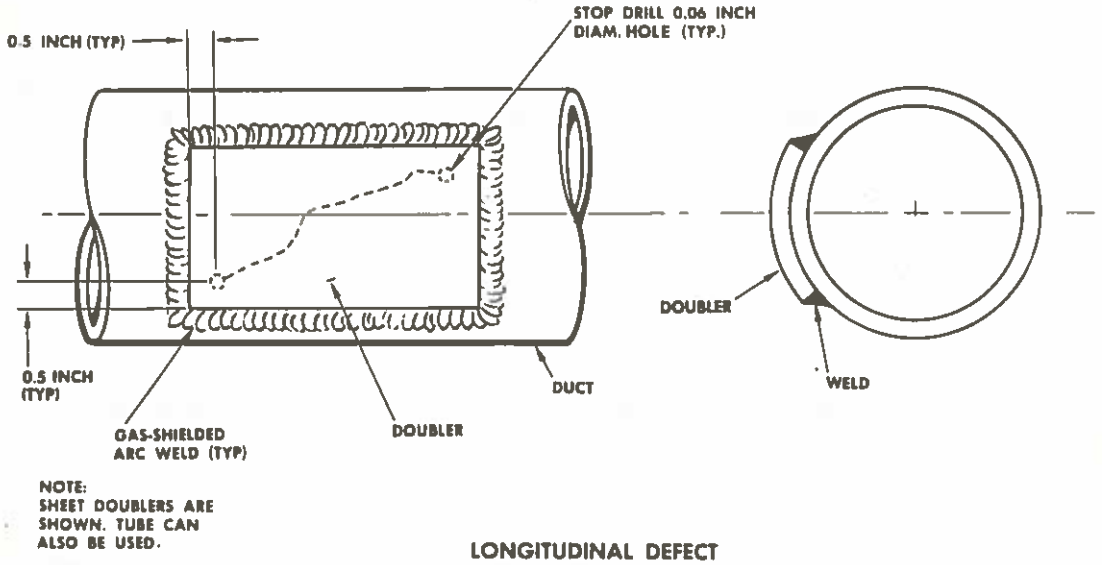
3) Manufacture doubler from tube or sheet of same type material and one gage heavier than duct material, to completely surround duct, or doubler should extend beyond crack 1/2 inch minimum at each edge.

4) Install doubler over damaged area.

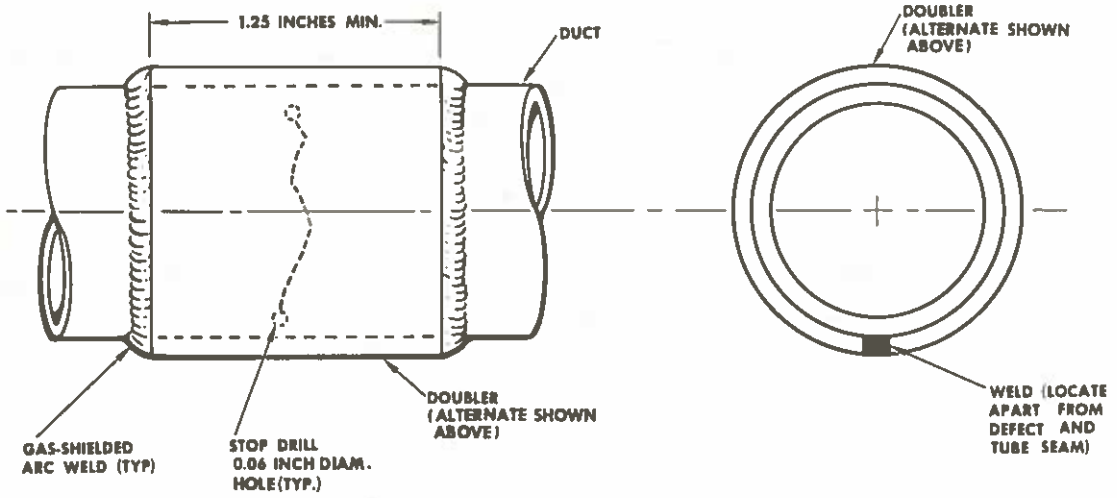
5) Weld doubler to duct, using fusion type weld while purging duct with inert gas.



CRACKED SEAM WELD



LONGITUDINAL DEFECT



CIRCUMFERENTIAL DEFECT

22.04.13.3.0.0058

6) Inspect as specified in paragraph 2.A.(10).

(b) Repair of cracked seam weld or hole in duct with doubler, (see Figure 405).

Cracks exceeding one inch in length in the seam weld of drop hammer-formed parts or hole in duct may be repaired as follows:

1) Clean damaged area.

2) If cracked, stop drill 0.060-inch diameter hole at each end of crack. If hole, cut out damaged area until original metal thickness reached.

3) Grind original weld smooth in area to be covered by doubler.

4) Manufacture doubler from sheet stock of same type material and one gage heavier than duct material. Doubler must not be less than 1.25 inches wide and must extend beyond ends of crack or hole a minimum of 0.50 inch.

5) Weld doubler to duct, using fusion type weld while purging duct with inert gas.

6) Inspect as specified in paragraph 2.A.(10).

(9) Duct replacement.

(a) Duct section (see Figure 406).

Where a section of duct is damaged beyond repair, but it is desirable to salvage the major portion of the assembly, the damaged section may be cut out and a new section inserted. Various combinations of insertions may be employed (see Figure 406), provided the following points are observed:

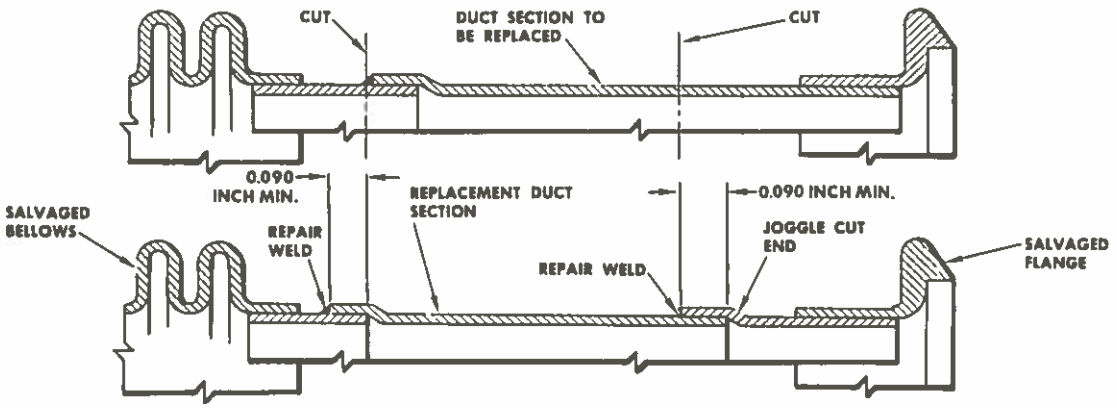
1) Ends of ducts must be deburred after cutting out damaged section.

2) Insert section must be made from the same type material and gage thickness as original duct material.

3) Insert section is carefully matched or sized to duct to insure a satisfactory weld, especially if roll type seam weld is employed.

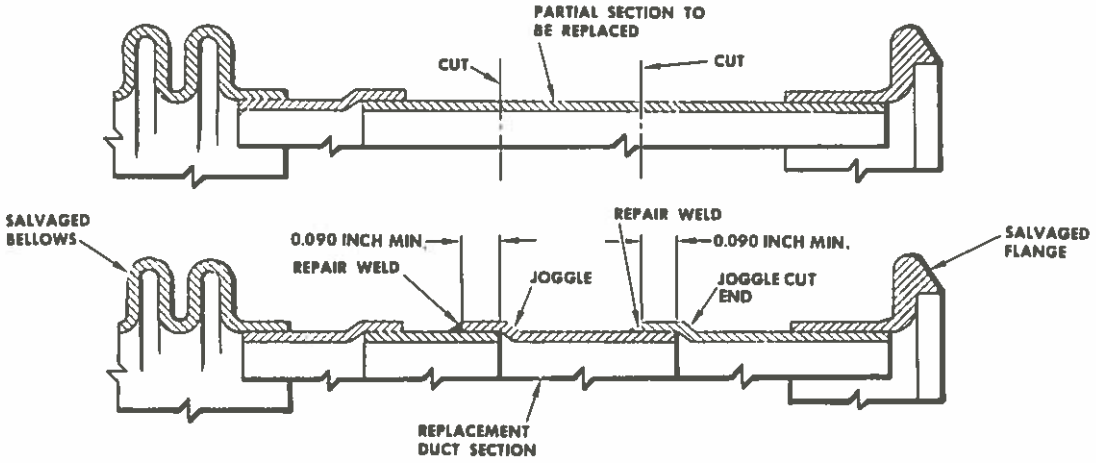
4) Duct assembly must be supported in weld fixture to maintain original drawing dimension, and prevent distortion.

5) The type of weld is optional (see Figure 403), but if duct is a drop hammer-formed part, fusion type weld must be used.

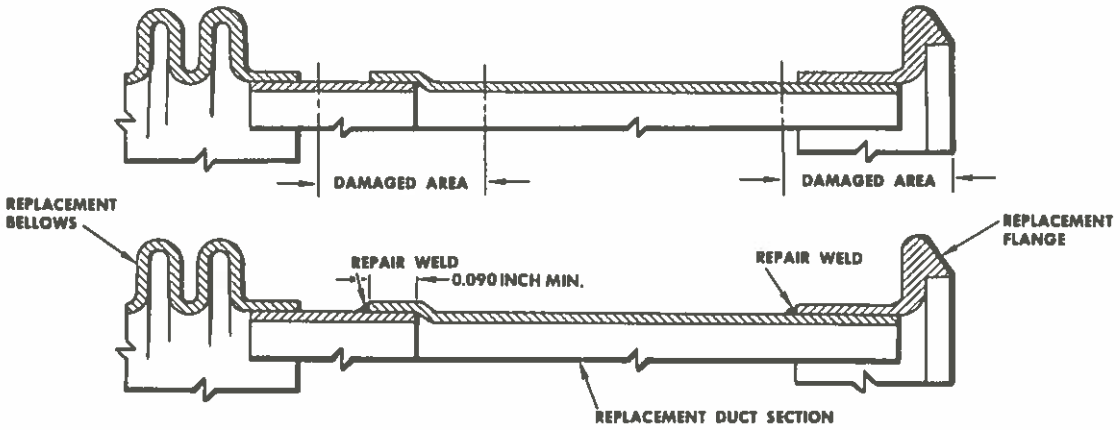


CAUTION:
DO NOT CUT TIE ROD STRUT WHEN CUTTING THROUGH BELLOWS COLLAR.

NORMAL SECTION REPLACEMENT



PARTIAL SECTION REPLACEMENT



SECTION AND COMPONENT REPLACEMENT

22.06.13.5.8.006

6) Minimum of 0.090-inch overlap at joggle must be maintained.

7) Ducts must be inspected as specified in paragraph 2.A.(10) after welding.

(b) Bellows replacement (see Figure 407).

A bellows assembly with damage exceeding limits described in paragraph 2.A.(3) may be replaced as follows:

1) Cut damaged bellows from duct assembly.

2) Deburr duct ends and maintain joggle dimension of 0.090 inch minimum. If minimum joggle dimension cannot be maintained, cut off joggled area and fit a repair collar.

3) If bellows assembly is joggled instead of the duct section, fit a repair collar (see Figure 403).

4) Fit replacement bellows and install duct assembly in weld fixture, to maintain drawing dimensions.

CAUTION: INSURE THAT REPLACEMENT BELLOWS ASSEMBLY IS CORRECT PART NUMBER FOR DUCT ASSEMBLY. BELLOWS ASSEMBLIES ARE DESIGNED FOR DIFFERENT OPERATING PRESSURES.

5) Inert gas arc weld bellows to duct assembly while purging with inert gas.

6) After welding, inspect as specified in paragraph 2.A.(10).

(c) Flange replacement (see Figure 407).

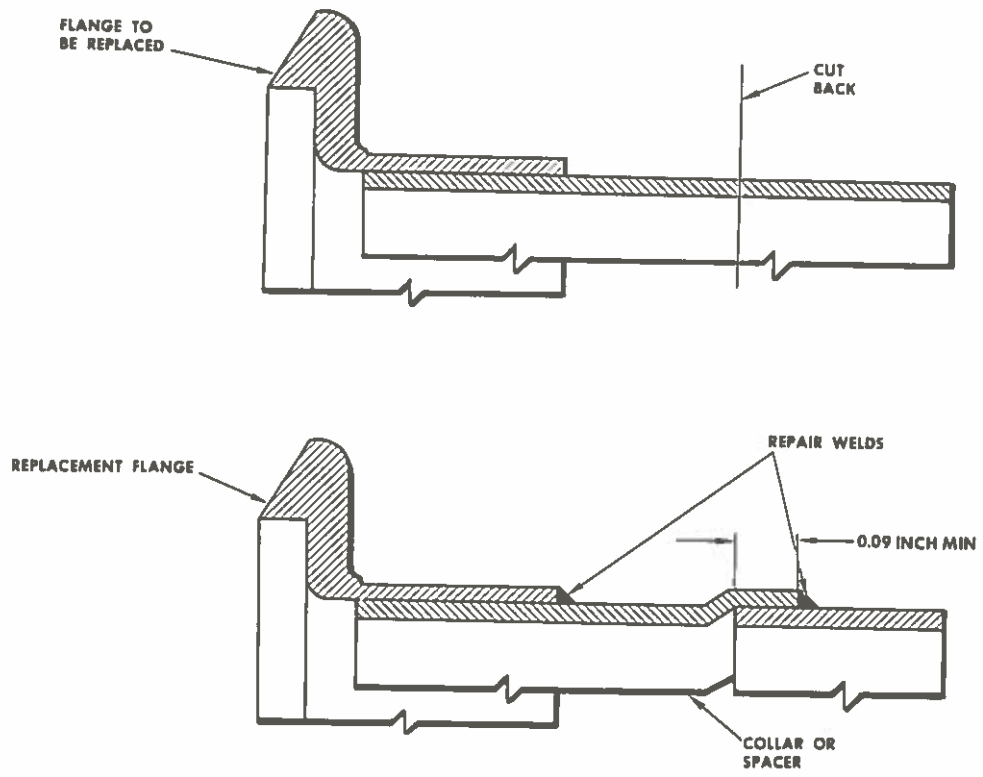
A flange with damage exceeding limits described in paragraph 2.A.(3) may be replaced by following the same procedure described in paragraph (b).

(10) Inspection of repaired duct.

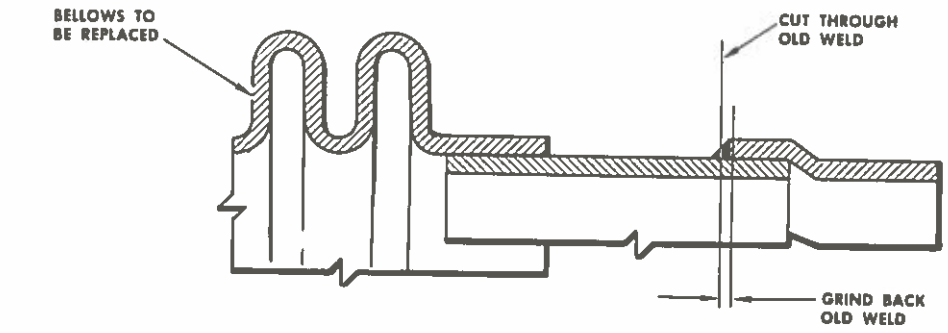
(a) General.

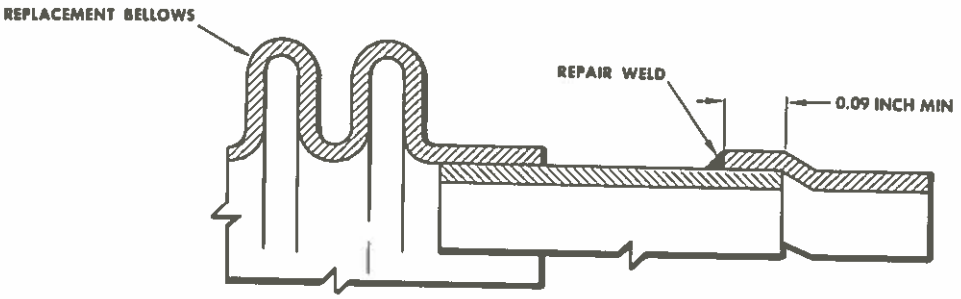
1) Proof pressure testing is required for any ducts that have been repaired.

2) Because of high pressures involved during proof pressure testing, a holding fixture is required for each duct assembly. In most cases the weld fixture can be used as a proof pressure test holding fixture.



FLANGE





BELLOWS

22.06.13.5.8.007

3) The bleed air source ducting on the engines is proof tested to 356 psig at 867 degrees F. Ducting downstream of the Engine Bleed Air Valves and upstream of the subsystems' control valves is tested to 237 psig at 867 degrees F. Ducting downstream of the subsystems' control valves is tested to 40 (± 5) psig at either 867 or 675 degrees F. , depending upon its proximity to the source.

4) Some representative proof test pressures used during overhaul are as follows:

SYSTEM	DUCT MATERIAL	PROOF TEST AT DEGREES PSIG	F
Engine bleed air manifold	Stainless steel 19-9DL or 321/347	356	867
Bleed air starting and engine inlet anti-ice duct	Stainless steel 19-9DL or 321/347	237	867
Wing bleed air duct and ground start valve stub duct	Stainless steel 19-9DL	237	867
Ducts to air conditioning -Pressurization system	Stainless steel 19-9DL	237	867
Pod lip anti-ice ducts	Stainless steel 321/347	40(±5)	867
Wing anti-ice ducts	Stainless steel 321/347 or titanium	40(±5)	867
Anti-ice duct telescopic feeder	Stainless steel 321 or 347	40(±5)	675

The proof pressure required to test a section of duct must be obtained from the applicable engineering drawing to insure that individual ducts are correctly tested for their specific environment and position in the aircraft systems.

The engineering drawing number is the same as the basic CONVAIR part number for a particular duct. The part number can be determined from the Illustrated Parts Catalog, and is also marked on each duct assembly.

(b) Duct inspection after repair.

1) All welds of duct assemblies must be inspected by dye penetrant method per Military Specification MIL-I-6866 before and after proof pressure testing. It is recommended that all repair welds be inspected by X-ray inspection per Military Specification MIL-I-6865.

(c) Duct proof pressure test.

1) Install duct assembly in pressure test fixture, with duct supported as shown on duct assembly drawing.

2) Pressurize duct assembly at proof pressure and temperature specified on duct assembly drawing. There must be no leaks.

3) Dimensionally check duct assembly for conformance to drawing dimensions.

4) Visually check duct assembly for deformation after proof pressure testing.

B. Duct Insulation.

(1) General.

There are two types of insulation used on ducts. The type used on earlier installations consists of fiberglas packing encased in a light metal shell and covered externally by a phenolic - fiberglas casing. The fiberglas packing may be of quarter-inch or half-inch wide rings. The assembled insulation is fitted to the duct in halves and sealed at the joints with adhesive aluminum tape. The insulation is secured to the duct by clamps, or double-wrapped lockwire.

An improved type of insulation fitted to later installations, consists of an outer casing of phenolic - fiberglas with a reflective inner surface of aluminum foil. The insulation is held away from the duct by integral stand-off rings of stainless steel. The insulation is one- or multiple-piece construction, and sealed at the joints with adhesive aluminum tape. The insulation is secured to the duct with lockwire at each stand-off ring.

The sections of both types of insulation are joined by a silicone impregnated fiberglas bellows coinciding with the duct bellows. The insulation bellows is joined to the insulation cover with adhesive aluminum tape and lockwire. The bellows used on earlier installations incorporates a fiberglas pad, enclosed in stainless steel mesh, fitted between the insulation bellows and the duct bellows. Later bellows have a reflective inner surface and do not require the use of the insulation pad.

(2) Cleaning insulation cover.

Before any patch repairs are performed, the damaged area must be cleaned of any dust, surface oils, or foreign matter, by wiping the surface with an acetone-moistened clean cloth.

CAUTION: DO NOT SATURATE THOMPSOGLAS INSULATION, AS GASSING WILL OCCUR DURING CURING AND PREVENT BONDING OF PATCH.

(3) Tools and equipment.

The following tools and equipment, or equivalent, should be available:

(a) No. 112 glass fabric volan finish. Coast Manufacturing Company, Livermore, California.

(b) No. 112 glass fabric volan impregnated with F-120 resin. Chrysler Corporation, Los Angeles, California.

(c) Cycleweld C-14 epoxy adhesive and catalyst. Chrysler Corporation, Los Angeles, California.

(d) Black paint, Hitco No. 131. H. I. Thompson Fiberglass Company, Inglewood, California.

(e) Cellophane lagging tape and sheet. Zellerbach Paper Company, Los Angeles, California.

(f) Pressure sensitive cellophane tape. Minnesota Mining and Manufacturing Company, Los Angeles, California.

(g) Acetone. Shell Chemical, Los Angeles, California.

(h) Sandpaper, No. 240 and 320 grit.

(i) Clean cloth or cheesecloth.

(j) Razor knife.

(k) Heat sealing iron or heat lamp.

(l) Hard rubber or plastic scraper.

(m) Adhesive aluminum tape, 3M No. Y 9050 or No. 361, Minnesota Mining & Manufacturing Co., St. Paul 6, Minnesota. Alternate: MYSTIK Tape Company No. 7455.

(4) Repair of damaged insulation.

(a) Preparation (see Figure 408).

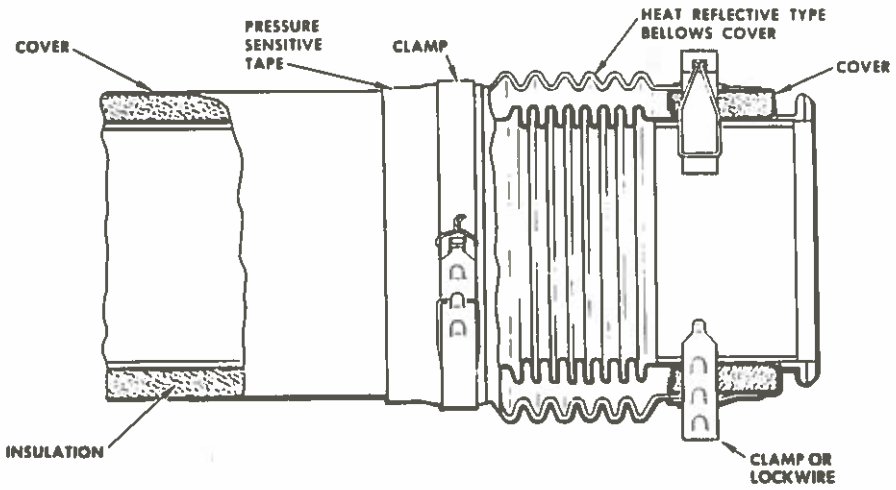
1) Cut away surface plies of cover around damaged area with razor knife. Allow 0.5 inch minimum lap between all plies, and around damaged area.

2) If Thompsoglas insulation is damaged, cut out insulation.

3) Clean up cut-out area with sandpaper.

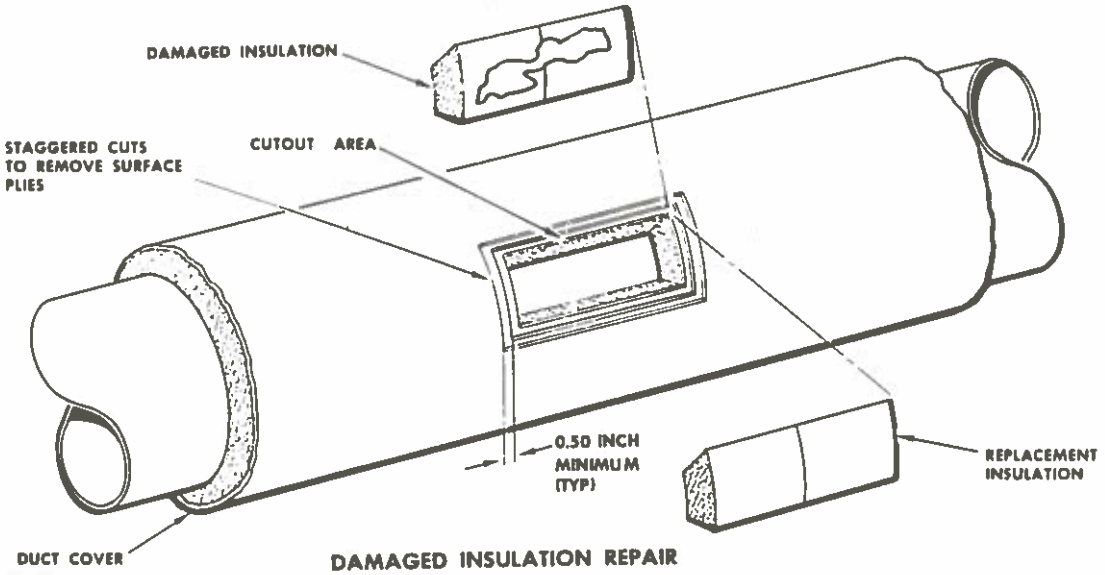
4) Cut replacement sections for insulation from 0.5-inch slab stock.

A



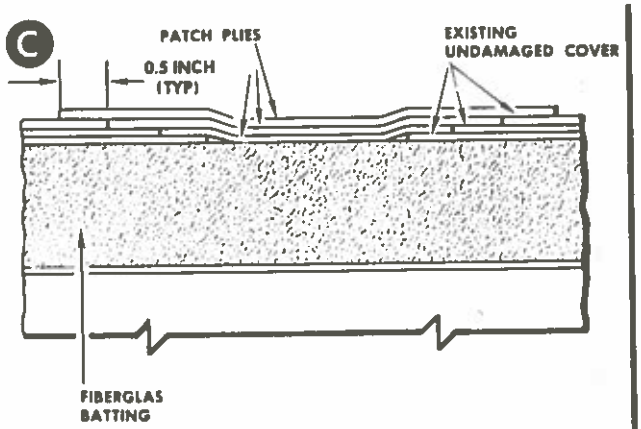
BELLOWS COVER INSTALLATION

B



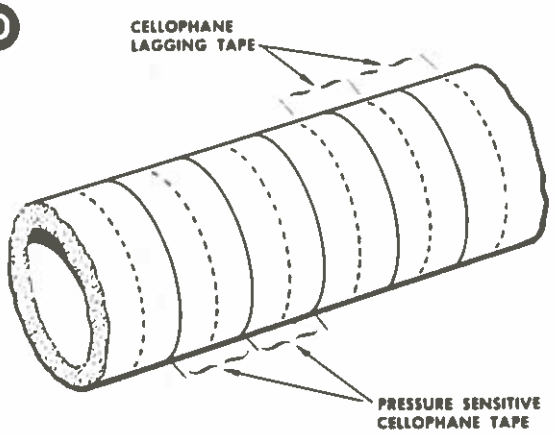
DAMAGED INSULATION REPAIR

C



PATCH PLIES INSTALLATION

D



LAGGING TAPE APPLICATION

22.06.13 5.8.008A

5) Insert repair pieces into cut-out area in the existing insulation and press or sand lightly until repair matches height of original insulation.

If insulation cover is damaged, it may be repaired by patching. The patch may be attached either by bonding with phenolic resin, as recommended in paragraph 2.B.(4)(b), or with adhesive, as recommended in paragraph 2.B.(4)(c).

(b) Bonding repair to insulation cover.

1) Cut patches of No. 112 glass fabric volan, impregnated with F-120 resin, to match cut-out areas in insulation cover. Lap all joints 0.5 inch minimum (see Figure 408).

2) Apply patches to cut-out area of insulation cover and bond with heat from a heat lamp or sealing iron.

3) Lag repaired area with 1.00-inch wide cellophane lagging tape and secure with 1.0-inch wide pressure sensitive cellophane tape (see Figure 408).

4) Cure in circulating air oven at the following periods and temperatures:

TIME (HOURS)	TEMPERATURE (DEGREES F)
1.0	175
1.5	225
1.5	250
2.0	300

5) Allow to cool in oven.

6) Remove lagging tape and sand down all rough edges.

CAUTION: DO NOT SAND INTO FIRST PLY OF FABRIC.

7) Seal insulation joints with aluminum tape, 3M No. Y 9050.

8) Paint black with Hitco No. 131 paint, or approved equivalent.

(c) Adhesive repair to insulation cover.

1) Cut patches of No. 112 glass fabric volan to match cut-out areas in insulation cover. Lap all joints 0.5 inch minimum (see Figure 408).

2) Weigh a small amount of cycleweld C-14 adhesive into a clean container and thoroughly mix with 7 percent (by weight) of catalyst. Use adhesive within 20 minutes after mixing.

CAUTION: USE A SMALL PADDLE OR STIRRING ROD TO MIX ADHESIVE AND CATALYST. AVOID CONTACT WITH SKIN. CATALYST SHOULD BE WASHED OFF SKIN IMMEDIATELY WITH STRONG SOAP.

3) Coat patches of No. 112 volan fabric with catalyzed cycleweld.

NOTE: Use a weight of cycleweld equal to the weight of the fabric.

4) Apply coated patches to cut-out area of insulation cover.

5) Lag repaired area with 1.0-inch wide cellophane lagging tape and secure with 1.0-inch wide pressure sensitive cellophane tape (see Figure 408).

6) Allow to cure at room temperature of 70 degrees F for a minimum of 48 hours.

7) Remove lagging tape and sand down all rough edges. Do not sand into first ply of fabric.

8) Seal insulation joints with aluminum tape, 3M No. Y 9050.

9) Paint black with Hitco No. 131 paint, or approved equivalent.

C. Weld fixtures.

(1) Weld fixtures must be employed during welding operations, to insure that the repaired duct configuration remains within designed dimensions.

(2) Weld fixtures can be locally manufactured, to simulate the installation into which a particular duct must fit.

(3) To manufacture an engine bleed air manifold assembly weld fixture, take measurements directly from the engine mount pads. The dimensions and geometry for manufacturing other weld fixtures may be obtained from the applicable engineering drawing of the duct assembly; refer to paragraph 2.A. (10).

Chapter 21
AIR CONDITIONING

TABLE OF CONTENTS

The following list indicates the overhaul manual Chapter-Section-Units comprising Chapter 21, provided by General Dynamics/Convair. Refer to the List of Effective Pages (LOEP) preceding each section-unit for date and part number of assembly covered:

CHAPTER SECTION UNIT NO.	TITLE
21-7-2.....	Valve - Cabin Air Shutoff

Chapter 23
COMMUNICATIONS

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The following list indicates the overhaul manual Chapter-Section-Units comprising Chapter 23, provided by General Dynamics/Convair. Refer to the List of Effective Pages (LOEP) preceding each section-unit for date and part number of assembly covered:

CHAPTER SECTION UNIT NO.	TITLE
23-2-4	VHF Antenna - Blade Type
23-2-5	VHF Antenna - Flush Type
23-5-2	Service Interphone Jackbox
23-5-3	Service Interphone Jackbox
23-5-4	Service Interphone Jackbox
23-5-5	Service Interphone Jackbox

VHF ANTENNA-BLADE TYPE
(Convair Part No. 22-31006-3)

ATA No. 23-2-4

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22-1, 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-4, 22(M)-22, 30-5, 30-6, and 30-8

May 25/61

List of Effective Pages

CHAPTER	PAGE	DATE	CODE
23-2-4	i	May 25/61	A-3
	BLANK		
23-2-4	1	May 25/61	A-3
23-2-4	2	May 25/61	A-3
23-2-4	3	May 25/61	A-3
23-2-4	4	May 25/61	A-3
23-2-4	5	May 25/61	A-3
23-2-4	6	May 25/61	A-3
23-2-4	7	May 25/61	A-3
	BLANK		
23-2-4	IPC 1	May 25/61	A-3
23-2-4	IPC 2	May 25/61	A-3
23-2-4	IPC 3	May 25/61	A-3
	BLANK		

Chapter 23

VHF ANTENNA - BLADE TYPE
(Convair Part No. 22-31006-3)

1. Description and Operation

A. Physical Description

(1) The VHF antenna-blade type, Convair Part No. 22-31006-3, is a vertically polarized ground plane antenna. The radiating element of the blade type antenna is encased in a swept-back and streamlined fairing of laminated fiberglas. The blade type antenna is located on the lower fuselage centerline of the airplane and is a component of the communication system.

B. Leading Particulars.

(1) Dimensions:

(a) Blade Fairing	Length	13.27 inches
	Width	12.00 inches
(b) Antenna Base	Length	14.50 inches
	Width	3.25 inches
(c) Weight		5.2 pounds

C. Operation.

(1) The antenna receives and radiates rf energy over the vhf range from 118 mc to 136 mc.

2. Disassembly

A. The antenna assembly is a honeycomb structure, covered with fiberglas and bonded with a catalyzed resin.

B. Due to the type of construction, disassembly of the unit is not considered practicable.

3. Cleaning

WARNING: AVOID INHALATION OF FUMES AND DIRECT CONTACT WITH DRY CLEANING SOLVENT REFERENCED IN PARAGRAPH 3.A. THE SOLVENT AND FUMES RELEASED ARE TOXIC. KEEP SOLUTION AND CLEANED PARTS AWAY FROM OPEN FLAME.

A. Wipe the antenna with a clean cloth dipped in dry cleaning solvent recommended in paragraph 6.B.(1)(c).

CAUTION: DO NOT ALLOW DRY CLEANING SOLVENT TO SOAK ON PART BEING CLEANED.

4. Inspection

A. General.

(1) Inspection is limited to visual inspection of components, using a magnifying glass where applicable.

B. Inspection Data.

(1) (See IPC Figure 1.) Check rivets for looseness around the base of the antenna assembly.

(2) Check connector (6) for signs of crossed and stripped-threads or galling.

(3) Check base (7) for cuts, nicks, scratches, cracks, and elongated holes.

5. Repair

A. Repair is limited to replacing antenna connector and minor surface repairs of fiberglas laminates.

(1) Antenna connector.

CAUTION: DEVIATIONS FROM THESE PROCEDURES MAY LEAD TO IRREPARABLE DAMAGE TO THE ANTENNA.

(a) (See Figure 1.) Measure 1.25 inches from base of antenna, on antenna connector centerline and mark a reference point.

(b) Drill a 0.375-inch deep pilot hole, using a number 30 drill, at point located in step (a).

(c) Drill a 0.25-inch deep hole, using a 0.50-inch counterbore with a 0.125 by 0.125-inch pilot, using pilot hole prepared in step (b).

(d) Remove 0.125 by 0.125-inch pilot from 0.50-inch counterbore, and drill to a depth of 0.375 inch using 0.50-inch counterbore.

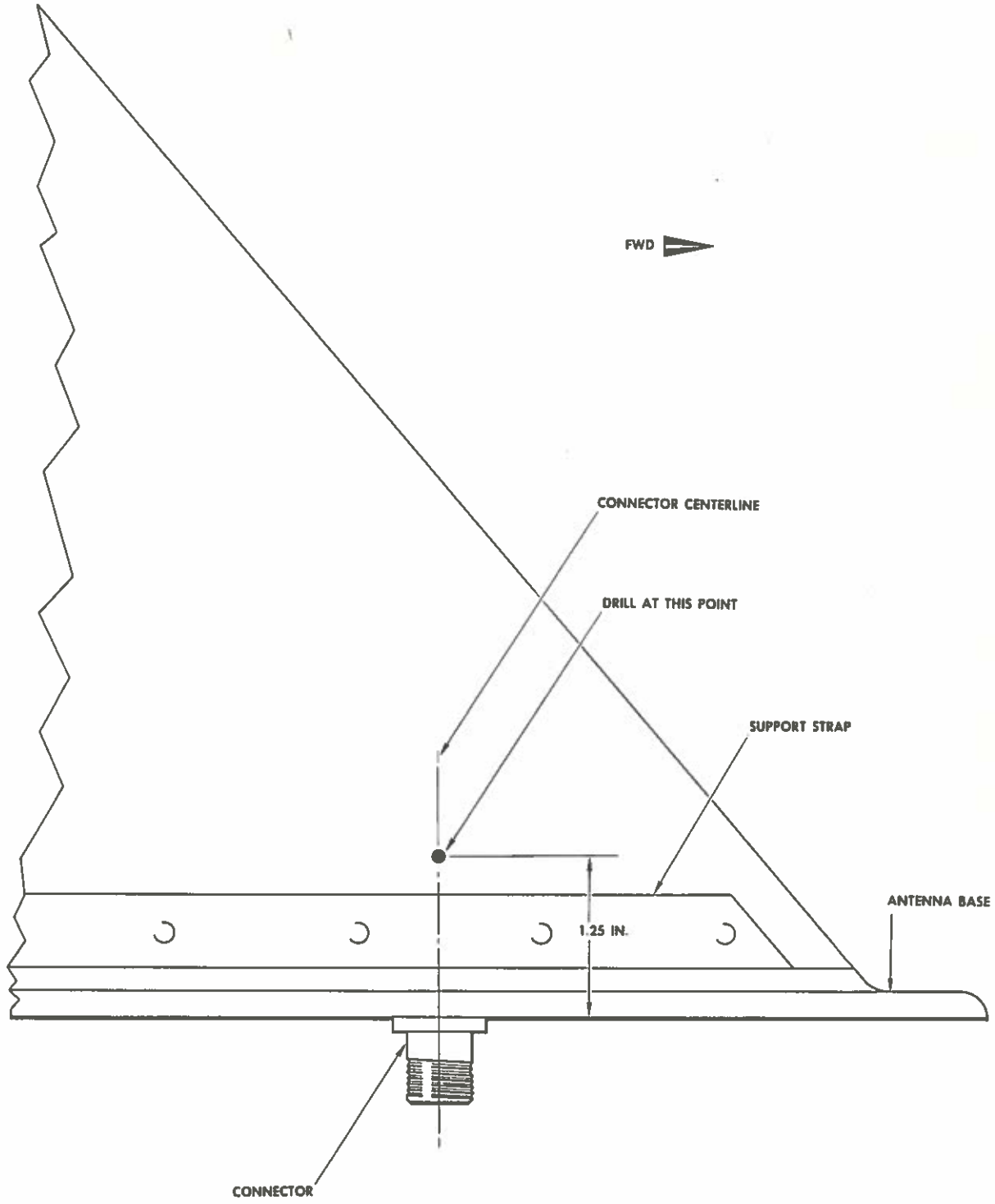
(e) Clean chips from hole.

(f) Unsolder and remove No. 14 GA Formvar wire from attaching point on antenna circuit board copper element.

(g) Grip antenna connector with suitable tool and unscrew and remove connector.

(h) Clean hole from which connector was removed.

(i) Solder an approximate 0.875-inch length of No. 14 GA Formvar wire to connector terminal, using solder listed in paragraph 6.B.(1)(h).



22.06 23 2.4.200

(j) Insert replacement connector, with wire attached, into threaded mounting hole with wire directed into hole at base of threaded mounting hole.

(k) Attach blank cap to connector and tighten.

(l) Grip blank cap with suitable tool and tighten connector to threaded mounting hole.

(m) Stake connector at four places on flange, 90 degrees apart.

(n) Remove blank cap from connector.

(o) Straighten 0.875-inch length of No. 14 GA Formvar wire, attached to the connector, and place end against antenna circuit board copper element.

(p) Solder 0.875-inch No. 14 GA Formvar wire to copper element.

(q) Clean all foreign matter from hole.

(r) Test connector to antenna circuit board element attaching lead for continuity; refer to paragraph 8.A.

(s) Repair hole in accordance with paragraph 5.(2).

(2) Minor repairs of fiberglas surfaces consist of filling in the damaged area with a mixture of catalyzed resin and chopped glass fibers; or laying in several layers of catalyzed resin-impregnated glass cloth. Wide abrasions will generally require patching with sections of glass cloth, while narrow scratches or gouges may be loaded with a thick mixture of chopped glass fibers and resin.

(a) Remove rough edges of scratch or abrasion by hand sanding with number 40 to 60 abrasive grit.

WARNING: AVOID INHALATION OF FUMES AND DIRECT CONTACT WITH TOLUENE REFERENCED IN PARAGRAPH (b). TOLUENE AND FUMES RELEASED ARE TOXIC AND HIGHLY EXPLOSIVE. KEEP TOLUENE AWAY FROM OPEN FLAME.

(b) Remove abrasive particles and dirt from repair area with a cloth moistened with toluene listed in paragraph 6.B.(1)(f).

(c) Damaged fiberglas areas may be filled with catalyzed resin. The required quantity of catalyzed resin can be prepared by thoroughly mixing the weights of resin and catalyst as indicated in either of the following:

Mix 100 parts resin with 25 parts catalyst as listed in paragraph 6.B.(1)(a), (d), and (e).

Mix 100 parts resin with 10 parts catalyst as listed in paragraph 6.B.(1)(b) and (e).

CAUTION: LEAVE CONTAINER OPEN AT ALL TIMES TO PREVENT POSSIBLE MILD EXPLOSION DUE TO GAS FORMATION.

NOTE: For narrow scratches or gouges, accomplish step (d). For wide abrasions, accomplish step (e).

(d) Prepare a thick paste of catalyzed resin mixed with glass fibers chopped from glass cloth. Work paste into scratch or gouge with flat blade or spatula until repair is slightly higher than surrounding area.

(e) Carefully sand surface in a roughly circular area around the abrasion to produce a neatly feathered or tapered edge.

CAUTION: DO NOT SAND BELOW THREE LAYERS OF FIBERGLAS LAMINATE.

(f) Taper edge about 0.50-inch wide around damage. Cut filler patches from a section of clean number 181 glass cloth, listed in paragraph 6.B.(1)(g). Cut patches large enough to overlap edges of sanded area. Brush damaged section and one filler patch with catalyzed resin. Apply this patch to damaged section, brushing out air bubbles and excess resin. Continue laying on resin-impregnated filler patches until repair is built up slightly above surface of surrounding area. With a cloth moistened in toluene, observing warning in step (a), remove excess resin which may have worked out around edges of repair.

(g) Cure repair at 150 to 200 degrees F from two to four hours, using portable infrared heat lamps or heating pads.

(h) After curing, remove excess material, then smooth surface of repair by hand sanding to proper contour with number 80 to 120 abrasive grit.

(i) Mix a small amount of resin with catalyst as specified in step (c), then brush mixture thinly over entire area of repair, overlapping repair about 0.5-inch. Allow to dry at room temperature. Do not sand after cure is completed.

CAUTION: THE ORIGINAL DIMENSIONS OF THE ANTENNA MUST NOT BE ALTERED WHEN MAKING REPAIRS.

6. Assembly

A. Assembly of antenna not included due to type of construction, refer to paragraph 2.

B. Materials.

(1) Use materials listed or equivalent, as specified.

MATERIAL	IDENTIFICATION	SOURCE
(a) Catalyst	Curing Agent T-1	Shell Chemical Corp. New York 20, New York
(b) Catalyst	Hardener 951	Furane Plastics, Inc. 4516 Brazil St. Los Angeles 39, California
(c) Dry cleaner	Federal Spec. P-S-661	Optional
(d) Resin	Epon 815	Shell Chemical Corp. New York 20, New York
(e) Resin	Epon 828	Shell Chemical Corp. New York 20, New York
(f) Toluene	Federal Standard JAN-T-171	Optional
(g) No. 181 Glass Cloth	Federal Spec. MIL-F-9084	Optional
(h) Solder	Federal Spec. 99-S571 - Comp. SN60	Optional

7. Fits and Clearances

A. The repaired vhf blade type antenna must conform to the following dimensions and tolerances:

(1) Length..... 13.27 inches
(2) Width..... 12.00 inches
(3) Thickness..... 1.00 inch
(4) Tolerance..... plus or minus 0.010 inch

8. Testing

A. Continuity Test.

NOTE: This test can be accomplished only when antenna is undergoing repair specified in paragraph 5.A.(1), step (r).

(1) (See IPC Figure 1.) Check for continuity between connector (6) pin and the connector lead wire attachment point on antenna circuit board copper element, using a standard volt-ohmmeter.

B. Connector Test.

(1) (See IPC Figure 1.) Check for continuity between connector (6) shell and antenna base (7) using a standard volt-ohmmeter.

C. VSWR Check.

(1) Check vswr with antenna mounted in position on aircraft; refer to Chapter 23, Maintenance Manual.

9. Trouble Shooting

A. Not applicable.

10. Storage Instructions.

WARNING: AVOID INHALATION OF FUMES AND DIRECT CONTACT WITH DRY CLEANING SOLVENT REFERENCED IN PARAGRAPH A. THE SOLVENT AND FUMES RELEASED ARE TOXIC. KEEP SOLUTION AND CLEANED PARTS AWAY FROM OPEN FLAME.

A. Install protective cap over connector. Store components of the antenna in crushproof cardboard cartons or wooden crates. Store only one component in each container to prevent excess weight from deforming the component. The containers need not be dust-proof as long as each component is carefully wiped with a clean, lint-free cloth moistened with dry cleaning solvent, listed in paragraph 6.B.(1)(c), prior to use.

CAUTION: DO NOT ALLOW DRY CLEANING SOLVENT TO SOAK ON PART BEING CLEANED.

11. Special Tools, Fixtures and Equipment

A. No special tools required.

ILLUSTRATED PARTS BREAKDOWN

VHF ANTENNA-BLADE TYPE
(Convair Part No. 22-31006-3)

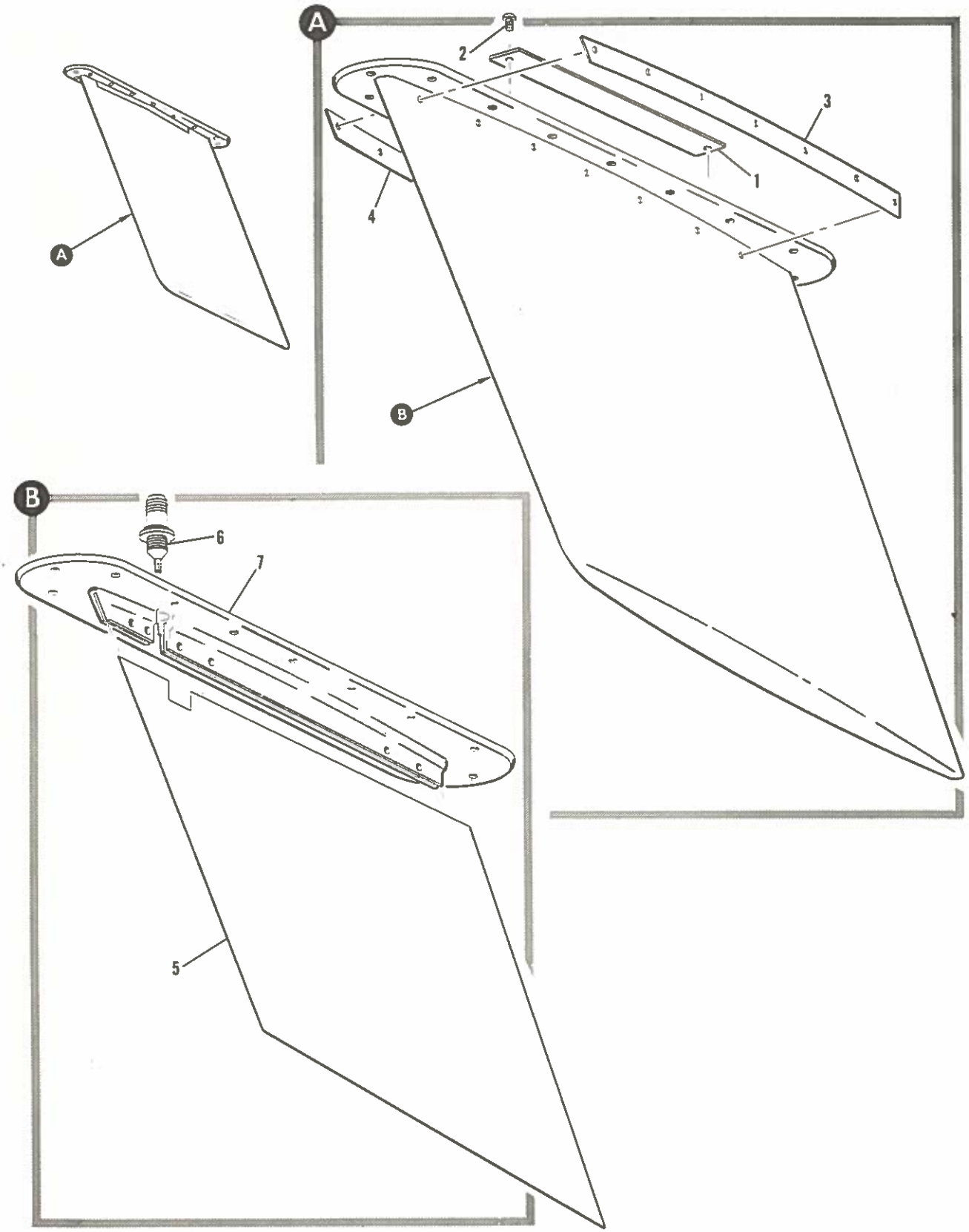
ATA No. 23-2-4

Applicable to Models 22-1, 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-4, 22(M)-22, 30-5, 30-6, and 30-8

May 25/61

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	22-31906-3	ANTENNA ASSEMBLY, VHF COMMUNICATION BLADE		1		1
-1	22-31008-9	. PLATE, IDENTIFICATION		1		1
		ATTACHING PARTS				
-2	AN535-0-4	. SCREW		1		2
		----X----				
-3	22-31009-9	. STRAP		1		1
-4	22-31009-10	. STRAP		1		1
	22-31006-7	. ANTENNA ASSEMBLY, VHF BLADE TYPE		1		1
-5	22-31005-7	. . BOARD, CIRCUIT ETCHED		1		1
-6	UC680U	. . CONNECTOR		1		1
-7	22-31007-9	. . BASE, VHF ANTENNA		1		1

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA-10B)

ATA No. 23-5-2

CONVAIR JET LINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-3, 22(M)-22, 30-6, and 30-8

July 28/61

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23-5-2	2	July 28/61	C-2
23-5-2	3	July 28/61	C-2
23-5-2	4	July 28/61	C-2
23-5-2	5	July 28/61	C-2
23-5-2	6	July 28/61	C-2
23-5-2	7	July 28/61	C-2
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23-5-2	IPC 1	July 28/61	C-2
23-5-2	IPC 2	July 28/61	C-2
23-5-2	IPC 3	July 28/61	C-2
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Chapter 23

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA-10B)

1. Description and Operation

A. Physical Description.

(1) The service interphone jack box part number JA-10B, is manufactured by Pan Air Electronics, Division of Electronic Equipment Engineering, Inc., Dallas, Texas, to the requirements of CONVAIR Specification Control Drawing Number 22-03433-3. This chapter contains complete step by step overhaul procedures, prepared by the manufacturer to standards established by Air Transport Association Specification Number 100, for inclusion in the CONVAIR overhaul manual.

(2) The service interphone jack box consists of an aluminum alloy box and a box cover. The jacks are protected externally by spring loaded covers. Two captive screws secure the jack box to the cover.

B. Leading Particulars.

Overall Height	2.75 inches
Overall Width	2.20 inches
Overall Length	4.75 inches
Weight	0.50 pound

C. Operation.

Operation consists of connecting the unit to the communications system and inserting plug or plugs of appropriate equipment into proper jacks.

2. Disassembly

A. General.

The service interphone jack box should be disassembled only as necessary to reach and replace defective parts or wiring. Unsolder electrical connections as required, exercising care not to unsolder adjacent wires. Do not overheat.

B. Jack Box.

(1) (See IPC Figure 1.) Remove screws (16), cover (1) and gasket (2) from jack box (15).

(2) Unsolder and remove wires from jacks (4), (5) and (6) and switch (9).

(3) Remove nuts securing jacks (4), (5) and (6).

(4) Remove jack covers (3) and washers (8) from jacks (4), (5) and (6) and remove jacks from jack box (15). Remove washers (7) from jacks.

(5) Remove nut and lockwasher securing switch (9) to jack box (15).

(6) Remove screws (12) and lockwashers (11) securing receptacle (10) to jack box (15).

(7) Remove screws (14) securing nameplate (13).

3. Cleaning

NOTE: Perform preliminary inspection as specified in paragraph 4, prior to commencing cleaning operations.

WARNING: USE SOLVENT IN A WELL VENTILATED AREA. AVOID PROLONGED INHALATION OF FUMES. KEEP SOLVENT FROM OPEN FLAMES.

A. External.

(1) Clean the jack box, cover and receptacle J1 with aliphatic naphtha specified in paragraph 6.C.(1)(b). Lubricate thread of receptacle after cleaning, with anti-seize compound specified in paragraph 6.C.(1)(c), and fit protective cap.

B. Internal.

(1) The interior of the jack box should be cleaned as specified in paragraph 3.B.(2) only if a defective condition exists. Apply cleaners and solvents with a small stiff-bristled brush. Thoroughly dry parts after cleaning, using dry filtered compressed air or nitrogen. Take care not to direct full air pressure at parts. Test the jack box after cleaning in accordance with paragraph 8.

(2) Cleaning.

(a) Clean before soldering with solvent specified in paragraph 6.C.(1)(a).

(b) Remove flux from soldered joint with isopropyl alcohol specified in paragraph 6.C.(1)(e).

4. Inspection

A. Preliminary Inspection.

(1) Preliminary inspection of the service interphone jack box should be made before initial cleaning, to determine obvious signs of damage.

B. Inspection Procedures.

(1) (See IPC Figure 1.) Remove cover (1) from jack box (15) and protective cap from receptacle (10).

(2) Visually inspect parts and wiring for correct installation.

(3) Check jacks (4), (5) and (6) by inserting the appropriate type plug and determining that all contacts make firmly.

(4) Check wiring for signs of damage or deterioration, and check all soldered joints.

C. Visually inspect parts as follows:

IPC FIG. & INDEX NO.	NOMENCLATURE	INSPECTION
1- 1	Cover	Check for corrision, cracks, fractures, damage, distortion.
- 3	Cover	Check for corrosion, damage, distortion.
- 4, -5, -6	Jacks J2, J3, J4	Check for corrosion, damage, distortion.
- 9	Switch S1	Check for damage, insulation.
-10	Receptacle J1	Check for corrosion, cracks, fractures, damage, distortion, insulation.
-13	Nameplate	Check for damage, illegibility.
-15	Jack Box	Check for corrosion, cracks, fractures, damage, distortion.

5. Repair

A. General.

Replace all parts which do not pass inspection. (See IPC Figure 1.) Replace gasket (2) at each overhaul.

B. (See IPC Figure 1.) Repair exterior finish of jack box (15) and cover (1) as follows:

(1) Remove any loose paint and thoroughly clean area to be refinished in accordance with paragraph 3.A.(1).

(2) Chemically treat exposed metal surfaces in accordance with Specification MIL-C-5541.

(3) Apply finish coating type 2, in accordance with Specification MIL-F-7179A.

6. Assembly

A. General.

Assembly is normally restricted to replacement of parts to effect repairs. Use appropriate steps of the following assembly instructions as necessary. Solder all connections with solder specified in paragraph 6.C.(1)(d) in accordance with MIL-S-6872.

B. Jack Box.

(1) (See IPC Figure 1.) Place washers (7) with shoulders up, on jacks (4), (5) and (6).

(2) Insert jack (4) into mounting hole marked HANDSET, from underside of jack box (15). Insure correct seating of washer (7).

(3) Place washer (8) and jack cover (3) on jack (4) and secure to jack box (15) with nut furnished with jack.

(4) Insert jack (5) into mounting hole marked HEADSET, from underside of jack box (15). Insure correct seating of washer (7).

(5) Place washer (8) and jack cover (3) on jack (5) and secure to jack box with nut furnished with jack.

(6) Insert jack (6) into mounting hole marked MIC, from underside of jack box (15). Insure correct seating of washer (7).

(7) Place washer (8) and jack cover (3) on jack (6) and secure to jack box (15) with nut furnished with jack.

(8) Insert switch (9) into mounting hole marked CALL, in top of jack box (15). Secure with lockwasher and nut furnished with switch.

(9) Insert receptacle (10) with keyway at the ten o-clock position, through mounting hole at end of jack box (15). Secure to jack box using four lockwashers (11) and four screws (12).

(10) (See Figure 1.) Wire jack box in accordance with schematic diagram. Solder all connections with solder as specified in paragraph 6.C.(1)(d).

(11) (See IPC Figure 1.) Place gasket (2) within cover (1), position cover on jack box (15) and secure with two screws (16).

NOTE: Insure cover (3) at HANDSET position does not foul screw (16). Reposition cover if necessary to maintain clearance.

(12) Position nameplate (13) on jack box (15) and secure with two screws (14).

(13) Test jack box in accordance with paragraph 8.

C. Materials.

(1) Use the following materials or equivalents as specified:

MATERIAL	IDENTIFICATION	SOURCE
(a) Solvent	Federal Specification P-S-661	Optional
(b) Aliphatic naphtha	Federal Specification TT-N-95A	Optional
(c) Anti-seize compound	276-LAO	Armite Laboratories Los Angeles, Calif.
(d) Solder	Federal Specification QQ-S-571 Comp. SN60	Optional
(e) Isopropyl alcohol	MIL-F-5566 or MIL-A-6091	Optional

7. Fits and Clearances

Not applicable.

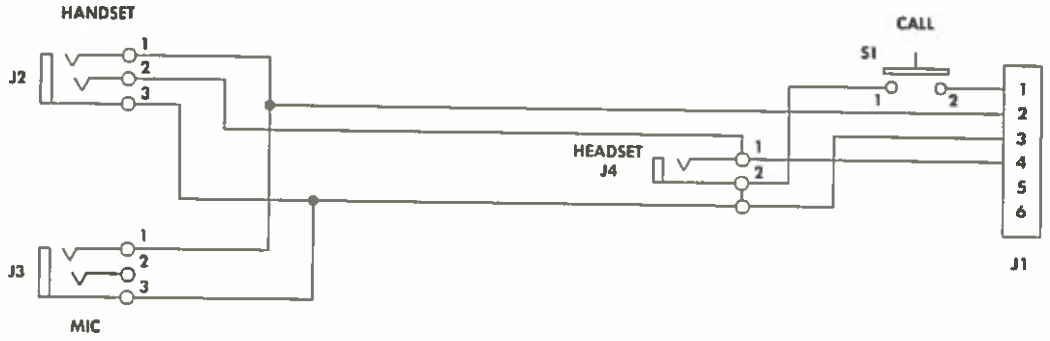
8. Testing

A. General.

Test the service interphone jack box using a standard volt-ohmmeter of 1,000 volt-ohms sensitivity. (See Figure 1.) Check circuits for continuity in accordance with schematic diagram.

9. Trouble Shooting

A. Trouble shooting should be conducted in conjunction with the tests specified in paragraph 8, and after inspection specified in paragraph 4.



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Service Interphone Jack Box -
Schematic
Figure 1

B. SERVICE INTERPHONE JACK BOX - TROUBLE SHOOTING (SEE IPC FIGURE 1.)

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
(1) HANDSET JACK J2 SHORTED TO GROUND	
Cover (3) fouling screw (16).	Lift cover (3), loosen nut securing jack (4) and reposition cover to insure clearance between cover and screw (16). Tighten nut (3) and check continuity.

10. Storage

A. Store the service interphone jack box as follows:

(1) Place protective cap on receptacle J1, place jack box in a suitable container and store in a cool dry place.

11. Special Tools, Fixtures and Equipment

Not applicable.

ILLUSTRATED PARTS BREAKDOWN

SERVICE INTERPHONE JACK BOX

(Pan Air Electronics Part No. JA-10B)

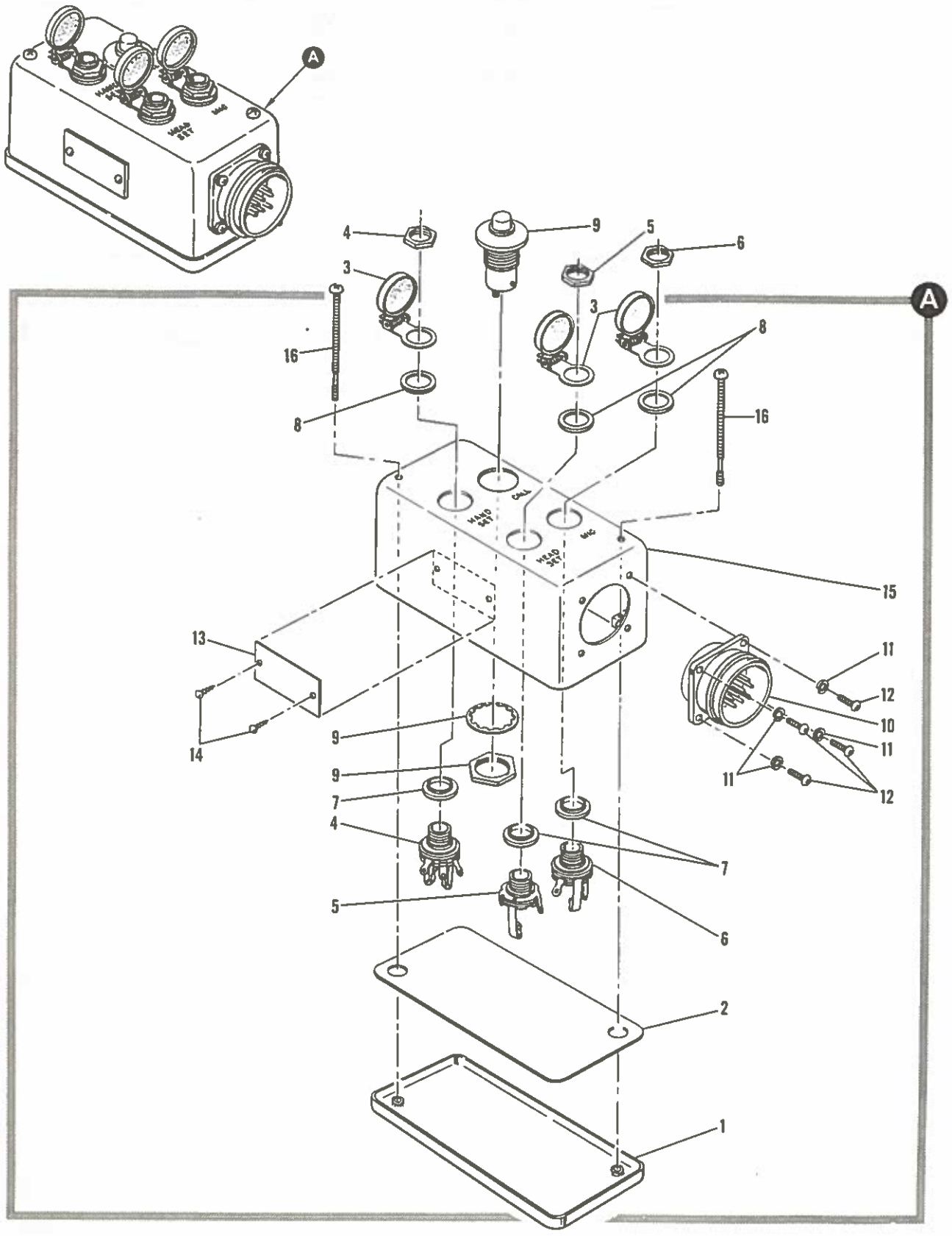
ATA No. 23-5-2

Applicable to Models 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-3, 22(M)-22, 30-6, and 30-8

July 28/61

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23-5-2	IPC 3	July 28/61	C-2
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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	JA10B	JACKBOX ASSEMBLY, SERVICE INTERPHONE SAME AS 1203-1 MFR TO SPEC CONT 22-03433-3 -V04970- P		1		REF
	1203-1	JACKBOX ASSEMBLY, SERVICE INTERPHONE TYPE JA10B -V04970- P		1		REF
- 1	1202-1	• COVER, -V04970- P		1		1
	1215-1	• INSERT, -V04970- P		1		2
- 2	1204-1	• GASKET, -V04970- P		1		1
- 3	1301-1	• COVER, JACK -V84636-		1		3
- 4	95-25	• JACK, -V81812- J2		1		1
- 5	SC1A	• JACK, -V76149- J4		1		1
- 6	SCA2B	• JACK, -V76149- J3		1		1
- 7	6529C	• WASHER, -V72653-		1		3
- 8	6517C	• WASHER, -V72653-		1		3
- 9	C100EB3	• SWITCH, -V99707- S1		1		1
- 10	WK6-32SL	• CONNECTOR, -V71468- J1 ATTACHING PARTS		1		1
- 11	AN935-6	• LOCKWASHER		1		4
- 12	6-32X3-8	• SCREW, -V71468- ----X----		1		4
	1215-1	• INSERT, -V04970- P		1		4
- 13	1067-2	• NAMEPLATE, -V04970- P ATTACHING PARTS		1		1
- 14	AN535-2-3	• SCREW ----X----		1		2
- 15	1201-1	• JACKBOX, -V04970- P ATTACHING PARTS		1		1
	1214-1	• FASTENER, -V04970- P		1		2
- 16	1216-1	• SCREW, -V04970- P ----X----		1		2

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA-10C)

ATA NO. 23-5-3

CONVAIR JET LINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22-1, 22-2, 22(M)-3, 22(M)-4,
22(M)-21-1, 22(M)-21-2, 22(M)-21-3,
22(M)-22, 30-5, 30-6, and 30-8 July 28/61

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23-5-3	2	July 28/61	A-2	23-5-3	IPC 1	July 28/61	A-2
23-5-3	3	July 28/61	A-2	23-5-3	IPC 2	July 28/61	A
23-5-3	4	July 28/61	A-2	23-5-3	IPC 3	July 28/61	A-2
23-5-3	5	July 28/61	A		BLANK		

Chapter 23

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA-10C)

1. Description and Operation

A. Physical Description.

(1) The service interphone jack box part number JA-10C, is manufactured by Pan Air Electronics, Division of Electronic Equipment Engineering, Inc., Dallas, Texas, to the requirements of CONVAIR Specification Control Drawing Number 22-03433-5. This chapter contains complete step by step overhaul procedures, prepared by the manufacturer to standards established by Air Transport Association Specification Number 100, for inclusion in the CONVAIR overhaul manual.

(2) The service interphone jack box consists of an aluminum alloy box and a box cover. The jacks are protected externally by spring loaded covers. Two captive screws secure the jack box to the cover.

B. Leading Particulars.

Overall Height	2.75 inches
Overall Width	2.20 inches
Overall Length	4.75 inches
Weight	0.50 pound

C. Operation.

Operation consists of connecting the unit to the communications system and inserting plug or plugs of appropriate equipment into proper jacks.

2. Disassembly

A. General.

The service interphone jack box should be disassembled only as necessary to reach and replace defective parts or wiring. Unsolder electrical connections as required, exercising care not to unsolder adjacent wires. Do not overheat.

B. Jack Box.

(1) (See IPC Figure 1.) Remove screws (15), cover (1) and gasket (2) from jack box (14).

(2) Unsolder and remove wires from jacks (4), (5) and (6).

(3) Remove nuts securing jacks (4), (5) and (6).

(4) Remove jack covers (3) and washers (8) from jacks (4), (5) and (6) and remove jacks from jack box (14).

(5) Remove washers (7) from jacks (4), (5) and (6).

(6) Remove screws (11) and lockwashers (10) securing receptacle (9) to jack box (14).

(7) Remove screws (13) securing nameplate (12).

3. Cleaning

NOTE: Perform preliminary inspection as specified in paragraph 4, prior to commencing cleaning operations.

WARNING: USE SOLVENT IN A WELL VENTILATED AREA. AVOID PROLONGED INHALATION OF FUMES. KEEP SOLVENT FROM OPEN FLAMES.

A. External.

(1) Clean the jack box, cover and receptacle J1 with aliphatic naphtha specified in paragraph 6.C.(1)(b). Lubricate thread of receptacle after cleaning, with anti-seize compound specified in paragraph 6.C.(1)(c), and fit protective cap.

B. Internal.

(1) The interior of the jack box should be cleaned as specified in paragraph 3.B.(2) only if a defective condition exists. Apply cleaners and solvents with a small stiff-bristled brush. Thoroughly dry parts after cleaning, using dry filtered compressed air or nitrogen. Take care not to direct full air pressure at parts. Test the jack box after cleaning in accordance with paragraph 8.

(2) Cleaning.

(a) Clean before soldering with solvent specified in paragraph 6.C.(1)(a).

(b) Remove flux from soldered joint with isopropyl alcohol specified in paragraph 6.C.(1)(e).

4. Inspection

A. Preliminary Inspection.

(1) Preliminary inspection of the service interphone jack box should be made before initial cleaning, to determine obvious signs of damage.

B. Inspection Procedures.

(1) (See IPC Figure 1.) Remove cover (1) from jack box (14) and protective cap from receptacle (9).

(2) Visually inspect parts and wiring for correct installation.

(3) Check jacks (4), (5) and (6) by inserting the appropriate type plug and determining that all contacts make firmly.

(4) Check wiring for signs of damage or deterioration, and check all soldered joints.

C. Visually inspect parts as follows:

IPC FIG. & INDEX NO.	NOMENCLATURE	INSPECTION
1- 1	Cover	Check for corrosion, cracks, fractures, damage, distortion.
- 3	Cover	Check for corrosion, damage, distortion.
- 4, -5, -6	Jacks J2, J3, J4	Check for corrosion, damage, distortion.
- 9	Receptacle J1	Check for corrosion, cracks, fractures, damage, distortion, insulation.
-12	Nameplate	Check for damage, illegibility.
-14	Jack Box	Check for corrosion, cracks, fractures, damage, distortion.

5. Repair

A. General.

Replace all parts which do not pass inspection. (See IPC Figure 1.) Replace gasket (2) at each overhaul.

B. (See IPC Figure 1.) Repair exterior finish of jack box (14) and cover (1) as follows:

(1) Remove any loose paint and thoroughly clean area to be refinished in accordance with paragraph 3.A.(1).

(2) Chemically treat exposed metal surfaces in accordance with Specification MIL-C-5541.

(3) Apply finish coating type 2, in accordance with Specification MIL-F-7179A.

6. Assembly

A. General.

Assembly is normally restricted to replacement of parts to effect repairs. Use appropriate steps of the following assembly instructions as necessary. Solder all connections with solder specified in paragraph 6.C.(1)(d) in accordance with MIL-S-6872.

B. Jack Box.

(1) (See IPC Figure 1.) Place washers (7) with shoulders up, on jacks (4), (5) and (6).

(2) Insert jack (4) into mounting hole marked HANDSET, from underside of jack box (14). Insure correct seating of washer (7).

(3) Place washer (8) and jack cover (3) on jack (4), and secure to jack box (14) with nut furnished with jack.

(4) Insert jack (5) into mounting hole marked HEADSET, from underside of jack box (14). Insure correct seating of washer (7).

(5) Place washer (8) and jack cover (3) on jack (5), and secure to jack box (14) with nut furnished with jack.

(6) Insert jack (6) into mounting hole marked MIC, from underside of jack box (14). Insure correct seating of washer (7).

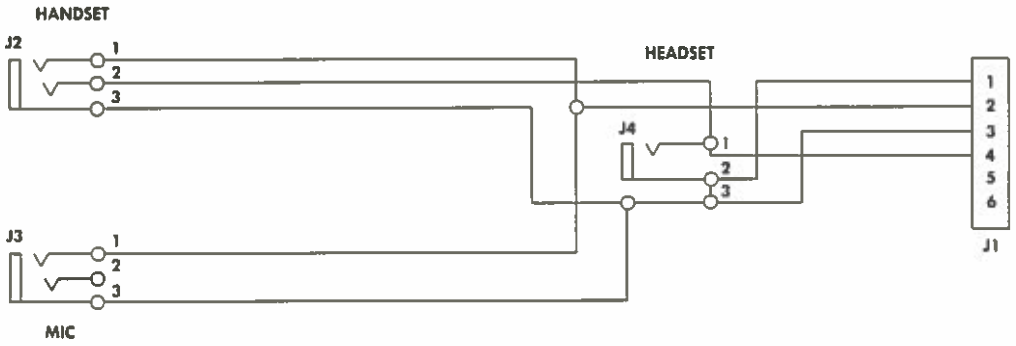
(7) Place washer (8) and jack cover (3) on jack (6) and secure to jack box (14) with nut furnished with jack.

(8) Insert receptacle (9) with keyway at ten o'clock position, through mounting hole at end of jack box. Secure to jack box using four lockwashers (10) and four screws (11).

(9) (See Figure 1.) Wire jack box in accordance with schematic diagram. Solder all connections with solder specified in paragraph 6.C.(1)(d).

(10) (See IPC Figure 1.) Place gasket (2) within cover (1), position cover on jack box (14) and secure with two screws (15).

NOTE: Insure cover (3) at HANDSET position does not foul screw (15). Reposition cover if necessary to maintain clearance.



22 06 23 3 3 001

(11) Position nameplate (12) on jack box (14) and secure with two screws (13).

(12) Test jack box in accordance with paragraph 8.

C. Materials.

(1) Use the following materials or equivalents as specified:

MATERIAL	IDENTIFICATION	SOURCE
(a) Solvent	Federal Specification P-S-661	Optional
(b) Aliphatic naphtha	Federal Specification TT-N-95A	Optional
(c) Anti-seize compound	276-LAO	Armite Laboratories Los Angeles, Calif.
(d) Solder	Federal Specification QQ-S-571, Comp. SN60	Optional
(e) Isopropyl alcohol	MIL-F-5566 or MIL-A-6091	Optional

7. Fits and Clearances

Not applicable.

8. Testing

A. General.

Test the service interphone jack box using a standard volt-ohmmeter of 1,000 volt-ohms sensitivity. (See Figure 1.) Check circuits for continuity in accordance with schematic diagram.

9. Trouble Shooting

A. Trouble shooting should be conducted in conjunction with the tests specified in paragraph 8, and after inspection specified in paragraph 4.

B. SERVICE INTERPHONE JACK BOX - TROUBLE SHOOTING (SEE IPC FIGURE 1)

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
(1) HANDSET JACK J2 SHORTED TO GROUND	
Cover (3) fouling screw (15).	Lift cover (3), loosen nut securing jack (4) and reposition cover to insure clearance between cover and screw (15). Tighten nut and check continuity.

10. Storage

A. Store the service interphone jack box as follows:

(1) Place protective cap on receptacle J1, place jack box in a suitable container and store in a cool dry place.

11. Special Tools, Fixtures and Equipment

Not applicable.

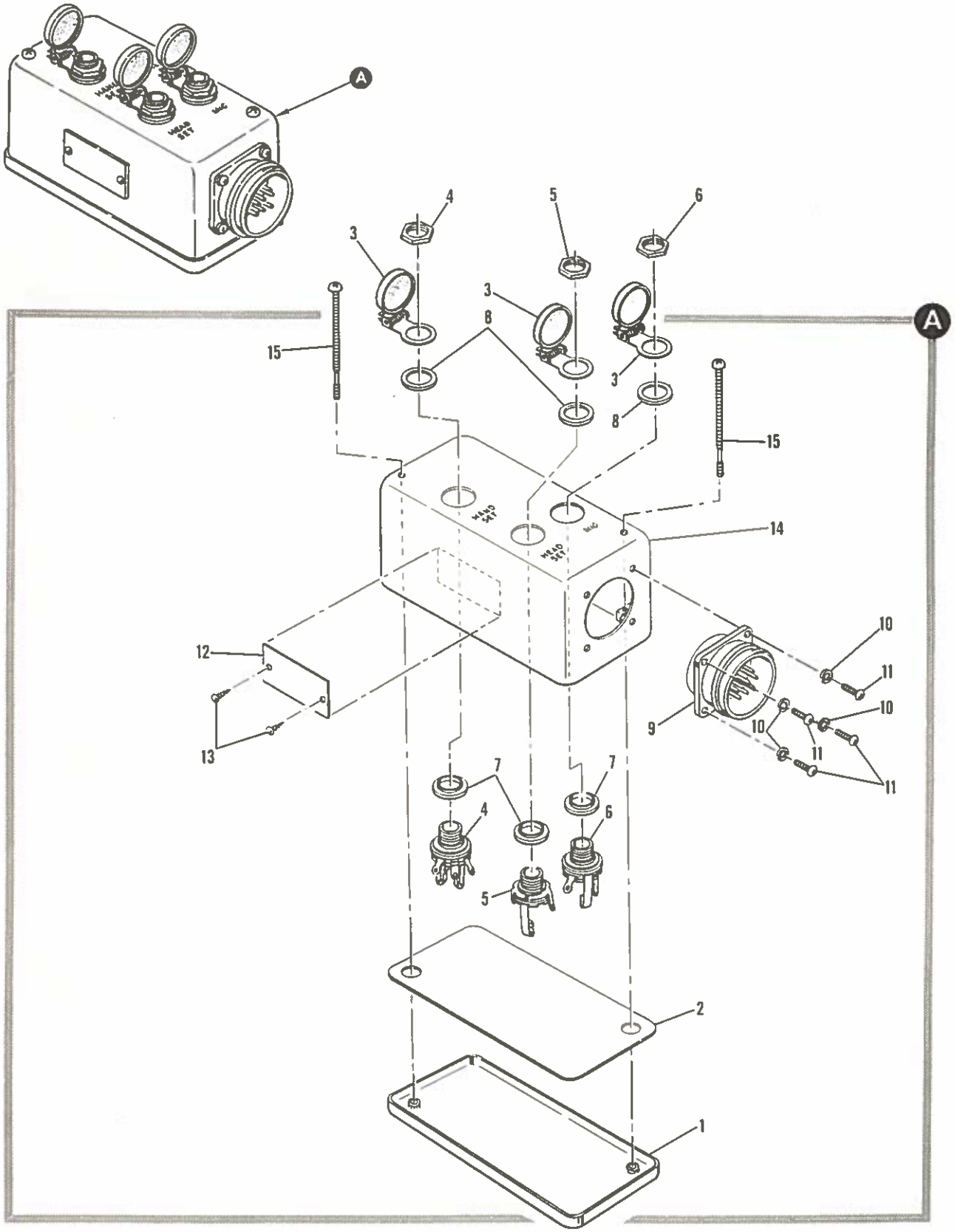
SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA-10C)

ATA No. 23-5-3

Applicable to Models 22-1, 22-2, 22(M)-3, 22(M)-4,
22(M)-21-1, 22(M)-21-2, 22(M)-21-3,
22(M)-22, 30-5, 30-6 and 30-8 July 28/61

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23-5-3	IPC 2	July 28/61	A		BLANK		



22-06-23-5-3-002

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
2	JA10C	JACKBOX ASSEMBLY, SERVICE INTERPHONE SAME AS 1203-2 MFR TO SPEC CONT 22-03433-5 -V04970- P		1		REF
	1203-2	JACKBOX ASSEMBLY, SERVICE INTERPHONE TYPE JA10C -04970- P		1		REF
- 1	1202-1	• COVER, -V04970- P		1		1
	1215-1	• INSERT, -V04970- P		1		2
- 2	1204-1	• GASKET, -V04970- P		1		1
- 3	1301-1	• COVER, JACK -V84636-		1		3
- 4	95-25	• JACK, -V81812- J2		1		1
- 5	SC1A	• JACK, -V76149- J4		1		1
- 6	SCA2B	• JACK, -V76149- J3		1		1
- 7	6529C	• WASHER, -V62653-		1		3
- 8	6517C	• WASHER, -V72653-		1		3
- 9	WK6-32SL	• RECEPTACLE, -V71468- J1 ATTACHING PARTS		1		1
- 10	AN935-6	• LOCKWASHER		1		4
- 11	6-32X3-8	• SCREW, -V71468- ----X----		1		4
	1215-1	• INSERT, -V04970- P		1		4
- 12	1067-2	• NAMEPLATE, -V04970- P ATTACHING PARTS		1		1
- 13	AN535-2-3	• SCREW ----X----		1		2
- 14	1201-2	• JACKBOX, -V04970- P ATTACHING PARTS		1		1
	1214-1	• FASTENER, -V04970- P		1		2
- 15	1216-1	• SCREW, -V04970- P ----X----		1		2

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA10 D)

ATA No. 23-5-4

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 30-5, 30-6 and 30-8 Dec. 15/61

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23-5-4	3	Dec. 15/61	AB
23-5-4	4	Dec. 15/61	AB
23-5-4	5	Dec. 15/61	AB
23-5-4	6	Dec. 15/61	AB
23-5-4	IPC 1	Dec. 15/61	AB
23-5-4	IPC 2	Dec. 15/61	AB
23-5-4	IPC 3	Dec. 15/61	AB
	BLANK		

2. Disassembly

A. To disassemble the service interphone jack box follow the procedure outlined below. Riveted assemblies are not to be disassembled.

B. Disassemble the jack box assembly as follows (See IPC Figure 1):

(1) Disconnect all wires from jacks (6), (7), (8) and switch (18).

(2) Remove jacks (6), (7), or (8) by removing nut (13), jack cover (4), and washers (11) and (12).

(3) Loosen and remove nut (16) and remove switch (18).

(4) Remove connector (5) by removing screws (14) and washers (15).

(5) Remove captive screws (10) by turning them ccw out of their guide blocks.

3. Cleaning (Not applicable)

4. Inspection

A. Inspection can be accomplished without disassembly.

(1) Inspect all wiring for signs of deterioration or damage.

(2) Inspect all solder connections.

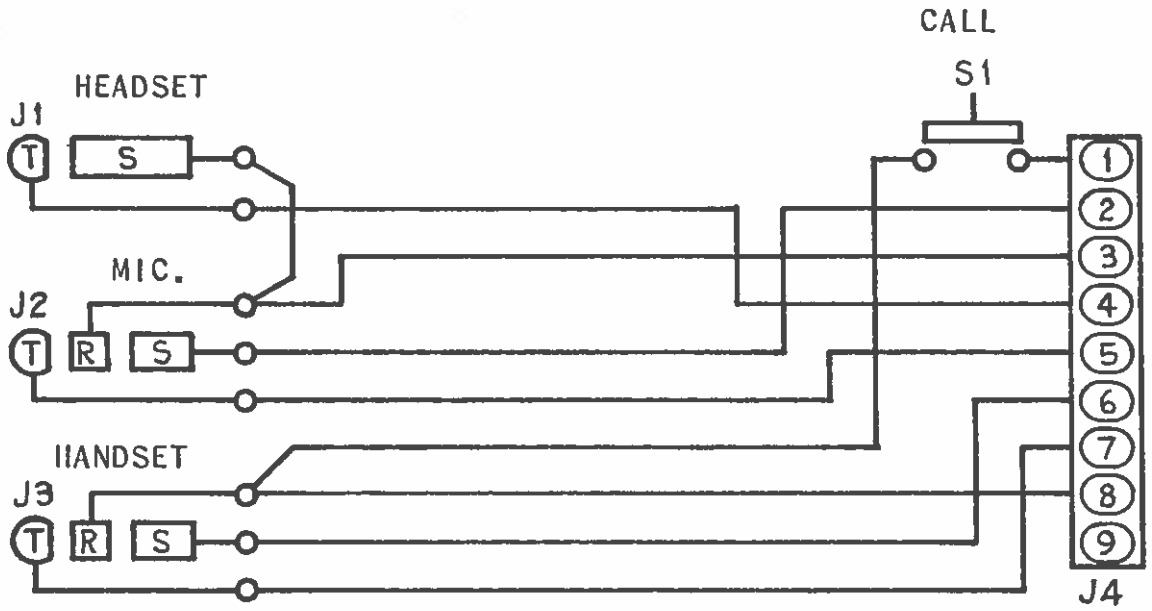
(3) (See IPC Figure 1.) Inspect all jacks (6), (7), and (8) by inserting the appropriate type plug and determine that all contacts make firmly.

(4) Inspect electrical connector (5) for signs of corrosion on pins and plug shell.

(5) Inspect shell of (5) for thread damage.

(6) Inspect jack covers (4) for tight fit against the jack.

(7) Inspect switch (18) push button for signs of damage.



Service Interphone Jack Box - Schematic
Figure 2

5. Repair

A. Service interphone jack box parts not meeting inspection requirements should be repaired as follows:

	Component	Repair
(1)	Jacks (6), (7), (8)	Replace
(2)	Push button (18)	Replace
(3)	Jack covers (4)	Replace
(4)	Connector (5)	Replace
(5)	Defective wiring	Replace
(6)	Defective hardware	Replace

6. Assembly

A. Assembly procedure for the service interphone jack box is as follows (see IPC Figure 1):

(1) Install jacks (6), (7), and (8) using insulated washers (11) and (12) and cover (4) securing with nut (13).

(2) Install switch (18) and secure with lockwasher (17) and nut (16).

(3) Re-install connector (5) using screws (14) and lockwashers (15).

(4) Rewire in accordance with schematic diagram (Figure 2).

(5) (See IPC Figure 1.) Install captive screws (10).

7. Fits and Clearances (Not Applicable)

8. Testing

Using an ohmmeter, check for continuity in accordance with the schematic diagram (see Figure 2).

9. Trouble Shooting

A. Not applicable.

10. Storage

A. Store in a cool dry place.

II. Special Tools, Fixtures and Equipment

A. No special tools, fixtures or equipment are needed.

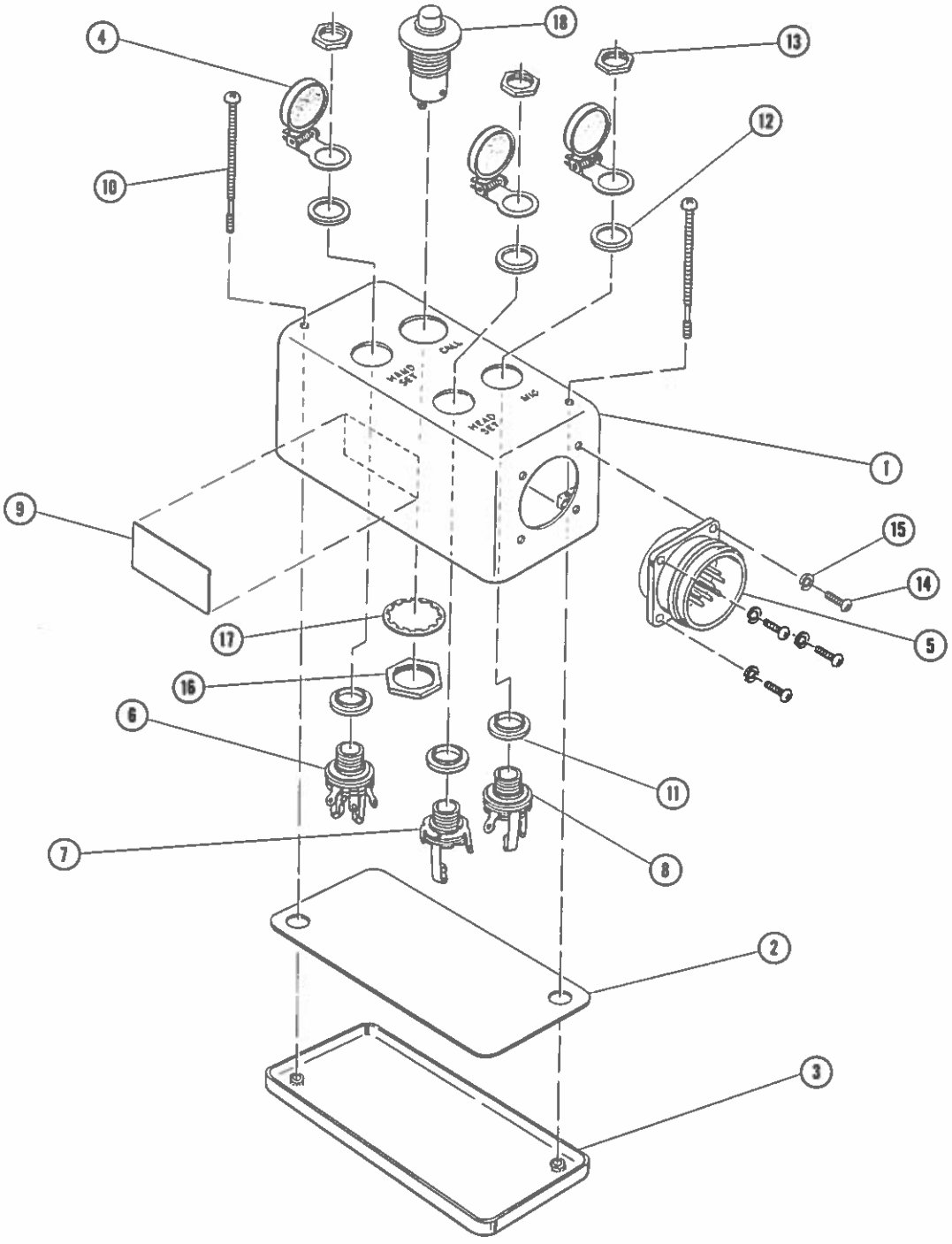
ILLUSTRATED PARTS BREAKDOWN

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA10 D)

Applicable to Models 30-5, 30-6 and 30-8 Dec. 15/61

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23-5-4	IPC 3	Dec. 15/61	AB
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Service Interphone Jack Box - Exploded View
IPC Figure 1

IPC Fig. & Index No.	Part Number	NOMENCLATURE 1 2 3 4 5 6 7	Units Per Assy
1-	JA10D	Jack Box Assembly - Service Interphone Mfd to Spec. Cont. Dwg 22-03433-7	Ref.
-1	300157-1	. Jack Box	1
-2	300158	. Gasket - Jack Box	1
-3	300159	. Cover - Jack Box	1
-4	300264	. Jack Cover (JAN 1301-1)	3
-5	300265	. Connector - V84636 - GK9-32S	1
-6	300267	. Jack - Handset - 95 - 25	1
-7	300268	. Jack - Headset - SC-1A - V76149	1
-8	300269	. Jack - SCA-2B Mic. - V76149	1
-9	300287	. Nameplate	1
-10	300064	. Captive Screw -	2
-11	300270	. Washer - Shoulder -V72653-6529C	3
-12	300271	. Washer - Flat-V72653-6517C	3
-13	551021	. Hex Nut 3/8 - 32	3
-14	551019-5	. Screw 6-32 x 3/8	4
-15	551020-3	. Lock Washer #6	4
-16		. Hex Nut (Part of Item 18)	1
-17		. Washer - Int. Tooth (Part of Item 18)	1
-18	300266	. Switch - V99707 - C100EB-3	1

SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA10E)

ATA No. 23-5-5

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 30-5, 30-6, and 30-8 Dec. 15/61

List of Effective Pages

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23-5-5	i	Dec. 15/61	AA
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23-5-5	IPC 3	Dec. 15/61	AA
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Chapter 23-5-5

SERVICE INTERPHONE JACK BOX

(Pan Air Electronics Part No. JA-10E)

1. Description and Operation

A. This section contains overhaul instructions for the service interphone Jack Box, part number 22-03433-13 manufactured by Pan Air Electronics, Division of Electronic Equipment Engineering, Inc., Dallas, Texas and designated as their part number JA-10E.

B. Physical Description (see Figure 1).

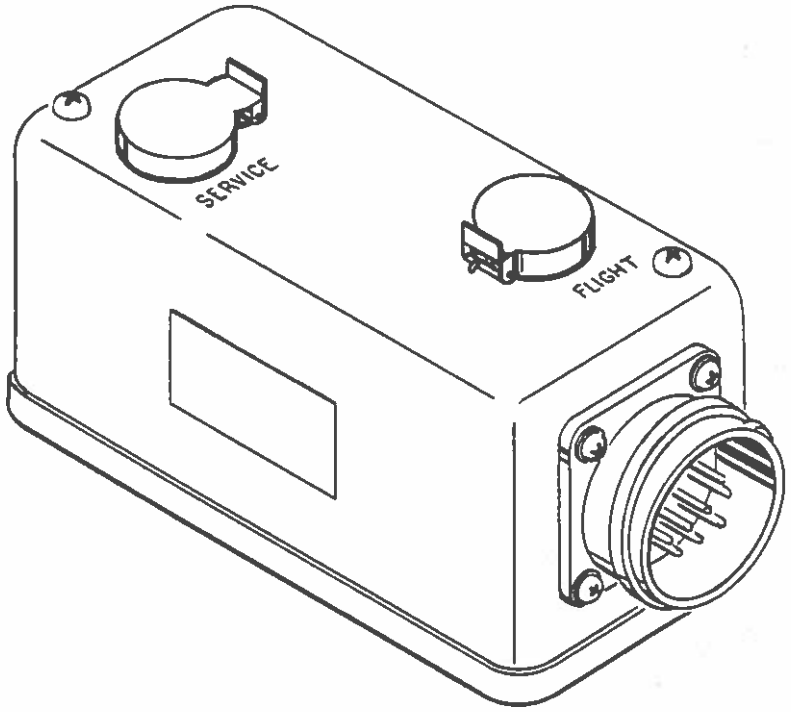
The service interphone jack box consists of two major components: The box proper and the base. These units are installed at various locations in the airframe.

C. Leading Particulars.

Overall height	2-3/4 inches
Overall width	2-1/8 inches
Overall depth	4-3/4 inches
Total weight	.5 pounds

D. Operation.

(1) The service interphone jack box provides the electrical connectors for interphone service between flight crews and ground or other personnel for the proper coordination of operational and service functions. The jacks are provided for service and flight intercommunication.


SERVICE
FLIGHT

2. Disassembly

A. To disassemble the service interphone jack box follow the procedure outlined below. Riveted assemblies are not to be disassembled. Numbers refer to illustrated parts list.

B. Disassemble the jack box assembly (see IPC Figure 1) as follows:

(1) Disconnect all wires from jacks (6).

(2) Remove nuts (13), covers (4), washers (12) and (11) and remove jacks (6).

(3) Remove screws (14), washers (15) and remove electrical connector (5).

(4) Remove captive screws(10) by turning them ccw out of their guide blocks.

3. Cleaning

A . Clean with dry pressurized air only.

4. Inspection

A. Inspection can be accomplished without disassembly (see IPC Figure 1).

(1) Inspect all wiring for signs of deterioration or damage.

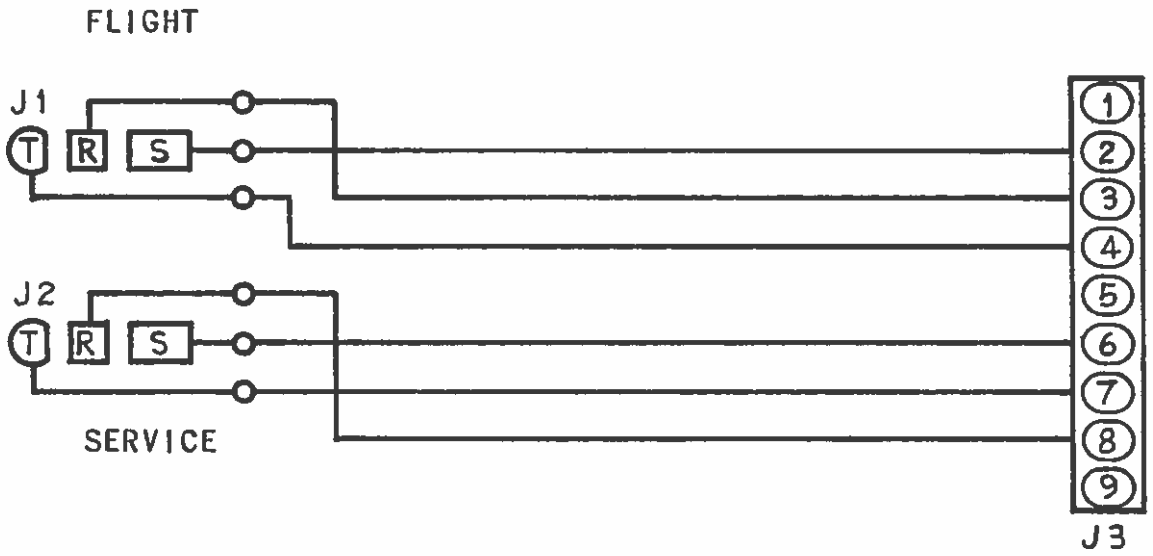
(2) Inspect all solder connections.

(3) Inspect both jacks (6) by inserting the appropriate type plug and determine that all contacts make firmly.

(4) Inspect electrical connector (5) for signs of corrosion on pins and plug shell.

(5) Inspect shell of electrical connector (5) for thread damage.

(6) Inspect jack covers (4) for tight fit against the jack (6).


FLIGHT
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SERVICE
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J3

5. Repair

A. Repairs to service interphone jack boxes (see IPC Figure 1) not meeting inspection requirements should be accomplished as follows:

	Component	Repair
(1)	Jacks - (6)	Replace
(2)	Jack covers (4)	Replace
(3)	Electrical connector (5)	Replace
(4)	Defective wiring	Replace
(5)	Defective hardware	Replace

6. Assembly

A. Assembly procedure for the service interphone jack box is as follows (see IPC Figure 1):

(1) Install jacks (6), insulated washers (11) and (12) and cover (4), with nuts (13).

(2) Re-install connector (5) using screws (14) and lockwashers (15).

(3) Rewire in accordance with schematic diagram (Figure 2).

(4) Install captive screws (10).

7. Fits and Clearances (not applicable)

8. Testing (not applicable)

Using an Ohmmeter, check for continuity in accordance with with the schematic diagram (see Figure 2).

9. Trouble Shooting

A. Not applicable.

10. Storage (not applicable)

11. Special Tools, Fixtures and Equipment

A. No special tools, fixtures and equipment required.

ILLUSTRATED PARTS BREAKDOWN

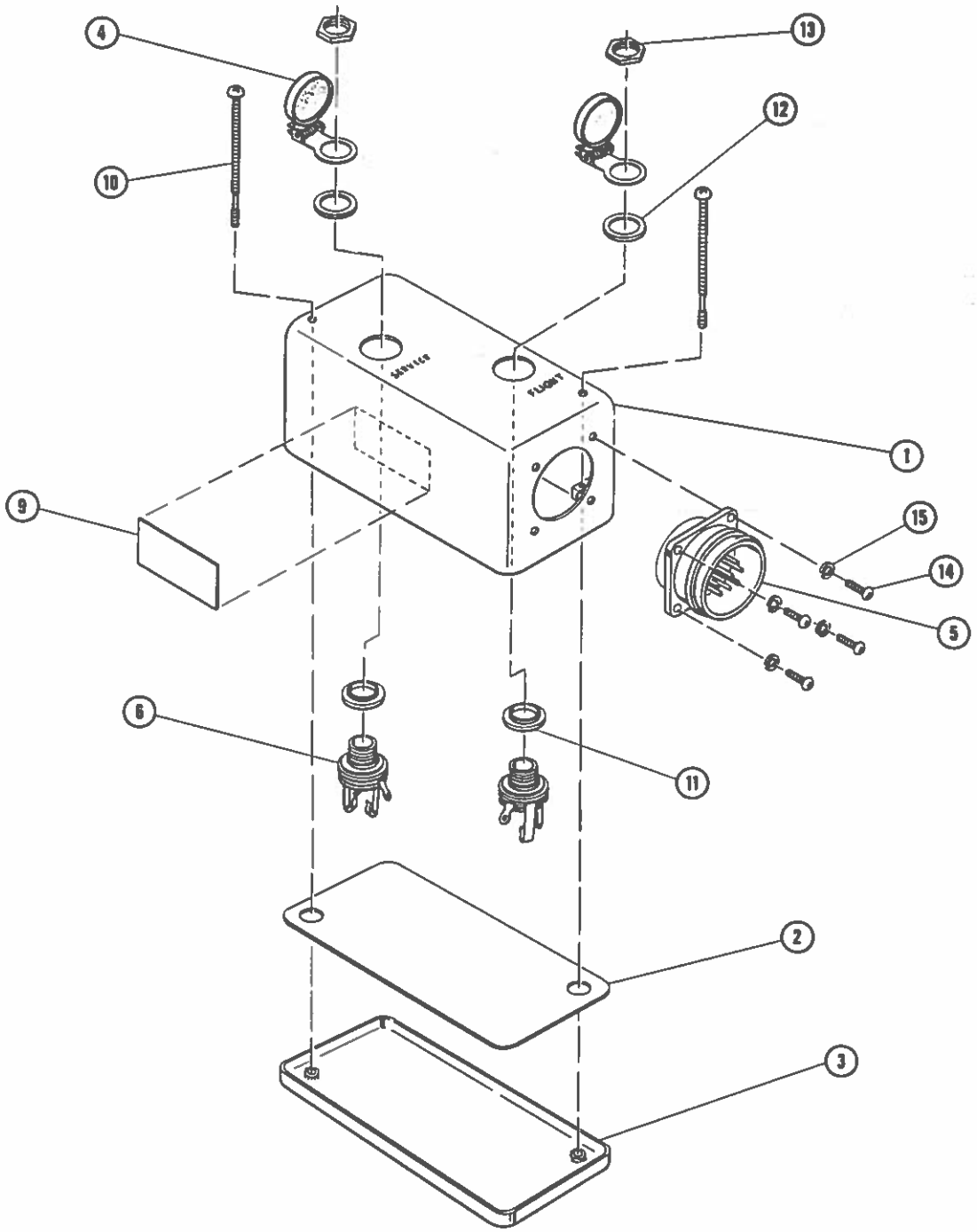
SERVICE INTERPHONE JACK BOX
(Pan Air Electronics Part No. JA10E)

ATA No. 23-5-5

Applicable to Models 30-5, 30-6, and 30-8 Dec. 15/61

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23-5-5	IPC 2	Dec. 15/61	AA		BLANK		


4
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11
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3

IPC Fig. & Index No.	Part Number	NOMENCLATURE 1 2 3 4 5 6 7	Usage Code	Units Per Assy
1-	JA-10E	Jack Box Assembly, Service Interphone Mfd to Spec. Cont. Dwg 22-03433-13		Ref.
-1	300157-1	. Jack Box		1
-2	300158	. Gasket, Jack Box		1
-3	300159	. Cover, Jack Box		1
-4	300264	. Jack Cover JAN1301-1		3
-5	300265	. Connector - V84636 - WK-6-32SL		1
-6	300267	. Jacks - 12B		2
-9	300287	. Nameplate		1
-10	300064	. Captive Screw		2
-11	300270	. Washer - Shoulder -V72653		2
-12	300271	. Washer - Flat -V72653		2
-13	551021	. Hex Nut 3/8 - 32		2
-14	551019-5	. Screw 6-32 x 3/8		4
-15	551020-3	. Lock Washer #6		4

CONVAIR MODEL 30

OVERHAUL MANUAL

Chapter 25
EQUIPMENT/FURNISHINGS

TABLE OF CONTENTS

The following list indicates the overhaul manual Chapter-Section-Units comprising Chapter 25, provided by General Dynamics/Convair. Refer to the List of Effective Pages (LOEP) preceding each section-unit for date and part number of assembly covered:

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25-1-3	Observer's Seat Installation
25-1-5	Navigator and Radio Operator's Seat
25-2-12	Club Compartment Seat Assemblies - Twin
25-2-32	Passenger Seat Assemblies - Double
25-2-33	Passenger Seat Assemblies - Triple
25-3-2	Aft Attendant's Aft Facing Seat - Sta 1378

CONVAIR MODEL 30

OVERHAUL MANUAL

FLIGHT ENGINEER'S SEAT
(Convair Part No. 22-98505-3)

ATA NO. 25-1-2

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 30-6 and 30-8 Oct. 10/62

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25-1-2	307	Oct. 10/62	AB
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25-1-2	IPC 1	Oct. 10/62	AB
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25-1-2	IPC 4	Oct. 10/62	AB
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25-1-2	IPC 13	Oct. 10/62	AB
25-1-2	IPC 14	Oct. 10/62	AB

Chapter 25-1-2

SECOND OFFICER'S AND FLIGHT ENGINEER'S SEATS
(Convair Part Nos. 30-96501-1 and 30-96501-3)

1. Description and Operation

A. Physical Description.

(1) The second officer's and flight engineer's seats, part numbers 30-96501-1 and 30-96501-3,are manufactured by Aircraft Mechanics, Inc., Colorado Springs, Colorado. This chapter contains complete step by step overhaul procedures, prepared by the manufacturer to standards established by Air Transport Association Specifications Number 100 for inclusion in the CONVAIR Overhaul Manual.

(2) The seat consists of two major components, the seat assembly and the base assembly. The seat is mounted on rails attached to the floor of the flight compartment.

(3) The seat provides a foam padded detachable seat cushion. All other cushions are cemented to structure. Seat belt and shoulder harness inertia reel are furnished.

B. Leading Particulars.

Overall height	38 1/2 inches
Base mounting	14 1/8 X 14 1/8 inches
Total weight	39 pounds
Capacity, occupant	200 pounds
Swivel	90 degree

C. Operation.

The operating features of the seat consist of three functions all manually controlled. These controls are located on the right hand side of the second officer's seat and on the left hand side of the flight engineer's seat.

The forward handle in both configurations operates the fore and aft track lock mechanism. The handle is attached to a push pull cable housed in a metal sheath. The cable is then attached, at the other end, to an inboard lever on a torque tube. On both ends of the torque tube are outboard levers with horizontal control pins attached. These pins are guided into the track by means of a bushing guide in the gripper above the rails locking the seat assembly in fore or aft position.

The aft control handle, in both configurations, operates the swivel control mechanism. This handle is attached to a rod assembly which is in turn attached to a bellcrank located on a swivel control guide. When actuated the swivel control guide pin, attached to the bellcrank, allows the seat to swivel ninety degrees with forty-five degree increments. When pin is released the seat locks in position.

The inertia reel control button is located aft of center line of the seat in both configurations. The control button attaches to a control lever which is attached to a torque shaft. The shaft in turn attaches to a second control lever which is attached to a control rod. The other end of the control rod attaches to a bellcrank on the inertia reel. By pushing the button control the inertia reel unlocks releasing the shoulder harness. The push button return is spring loaded eliminating manual lock control.

2. Disassembly

A. Seat Assembly. (See IPC Figure 1.)

(1) Release and remove belt (6).

(2) Remove seat cushion cover (3) and seat cushion pad (4). Remove seat back cover (16) and armrest covers (9).

(3) Unsnap seat back pocket (1) and left and right hand fairing assemblies (2).

NOTE: The contoured seat pan filler (5) is cemented to the seat pan and should be removed only if necessary for repair or replacement.

(4) Remove crotch strap fitting (7) by removing two bolts (8). Remove the seat back fairing (18) by removing nine screws (19).

NOTE: The seat back pad (17) is cemented to the seat back and should be removed only if necessary for repair or replacement.

(5) To disassemble armrest assembly remove two bolts (13), two washers (14) and two nuts (15) freeing stop fitting (12) from armrest structure assembly (11).

NOTE: Cushion (10) is cemented to armrest structure assembly and should be removed only if necessary for repair or replacement.

(6) Remove left and right hand armrest stop plates (20) and two armrest adjusting plates (22) by removing four bolts (21).

(7) Remove two pins (24), two pins (25) and two washers (26) freeing inertia reel control button (27), inertia reel control spring (28), washer (29) and control rod (38) from inertia reel (39). Remove pin (35), pin (36) and washer (37) freeing rod end (33) from control lever (31). Remove rod end (33) and nut (34) from control rod (38). Remove two screws (86), two washers (87) and two nuts (88) freeing support (89). Remove two pins (30) from the two control levers (31) freeing control shaft (32). Slide shaft out of support assembly. Remove bushings (90) from support (89). Remove inertia reel (39) by removing three bolts (40) and bolt (41).

(8) Remove two pins (42), pin (43), pin (44) and two washers (45) freeing swivel control rod assembly. Remove two rod ends (46), two nuts (47), two washers (48), spring (49) and control rod (50).

(9) Remove base fairing assembly (51) by removing ten screws (52).

(10) Remove bolt (53) and nut (54) securing cable (62). Remove two pins (55), two pins (56) and two washers (57), two control rod ends (58) and two nuts (59). Remove control washer (60) and spring (61) from cable (62).

(11) Remove screw (63), screw (64), two washers (65) and two nuts (66) from control handle (71) and control lever (68). Remove horizontal control torque tube (67), control lever (68), control spacer (69), spacer spring (70), control handle (71) and control handle (72) are free.

(12) From the seat structure assembly remove two lap belt attachment bolts (74), four washers (75) and two nuts (76).

(13) From the seat back assembly remove roller (77) by removing bolt (78), washer (79) and nut (80). Remove armrest bushing (81) and bushing (82) from seat back (83). Remove four bushings (84) from seat pan (85).

(14) Remove pip pin (73). Seat structure may now be lifted from base assembly.

B. Seat Base Assembly. (See IPC Figure 2.)

(1) Remove pin (1), washer (2), pin (4), releasing swivel control pin (7). Remove pin (1), washer (3) and pin (5) holding bellcrank (6). Remove swivel stop (13) by removing two screws (14), two washers (15) and two nuts (16). Rotate seat support tube. To remove control guide (8) and control bracket (12) remove two screws (9), two washers (10) and two nuts (11).

(2) Remove two pins (17), two pins (18) and two washers (19) releasing two control pins (25). Remove three screws (20), three washers (21) and three nuts (22) freeing two outboard horizontal control levers (23)and inboard lever (24). Slide out torque tube (26).

(3) Remove seat support tube assembly by removing four screws (27), four washers (28) and four nuts (29) freeing lower support bushing (35). Remove screw (30), washer (31) and nut (32). Do not remove tube support bushing (33) from support tube (34). Removal of bushing (33) would damage tube (34) beyond use.

(4) Remove four track rollers (36) by removing four roller adjust bolts (37), four woodruff keys (38), four washers (39), eight gripper washers (40), four gripper bushings (41) and four nuts (42). Remove gripper assemblies by removing four bolts (43), four flat washers (44) and four nuts (45). Remove bushing (46) and bushing (47) from base gripper (48). Remove bushing (49) from control bracket (50) leaving seat base (51).

3. Cleaning

A. General.

(1) Use soap and water to clean fabric upholstery assemblies while installed over foam rubber.

NOTE: Do not use cleaning solvents. Solvents will damage foam rubber.

(2) Use standard commercial dry-cleaning methods to clean upholstery assemblies removed from seat.

(3) Use soap and water to clean foam rubber.

(4) Clean metal parts with recommended cleaning solvent given in paragraph 6.C.

B. Recommended Cleaning Practices.

COMPONENT	RECOMMENDED CLEANING PRACTICE
Fairing Assembly	Wipe with water-moistened cloth
Fabric Upholstery Assembly	Dry clean
Belt Assembly	Dry clean
Vertical Adjustment Tube	Wipe with dry cloth, or clean
Machined Surfaces	Clean
Painted Surfaces	Wipe with water-moistened cloth
Armrest Assembly	Wipe with water-moistened cloth

4. Inspection

A. General.

It is not economical to carry out a detailed inspection of standard AN. NAS, MS parts. Where doubt exists concerning serviceability, a standard part should be renewed.

B. Visual Inspection.

Under strong light, preferably under magnification, visually inspect all parts as applicable, for scored or stripped threads, cracks, nicks, scratches, dents, corrosion, and excessive wear.

NOTE: Excessive wear shall be defined as any obvious deformation or deterioration of parts.

C. Dye Penetrant Inspection.

(1) Dye penetrant inspection may be used to check for cracks in forgings or castings, to check for holes in welded seams and to locate ends of cracks in skins and webs. Either fluorescent or non-fluorescent penetrants may be used.

(2) Black light used for fluorescent dye penetrant inspection must be filtered to pass only wave length band of 3200 to 4000 Angstrom units and have a power rating of not less than 100 watts.

WARNING: AVOID LOOKING DIRECTLY AT THE BLACK LIGHT SOURCE. FLUORESCENCE OF THE EYE ITSELF CAUSES HAZY VISION IF ANY DIRECT RAYS REACH THE EYE FROM THE BLACK LIGHT SOURCE. A MOMENTARY PERIOD OF READJUSTMENT WILL RESTORE SENSITIVITY OF VISION.

(3) Zyglo fluorescent dye-penetrant inspection

(a) Clean part by vapor degreasing.

(b) Apply film of dye penetrant specified in paragraph 6.C over area to be inspected by brushing, spraying or dipping.

(c) Allow dye to penetrate for the following periods:

Castings	5 to 10 minutes
Forgings	30 minutes
Skins and Webs	30 minutes

(d) Wash surface film of penetrant from part with water. Do not overwash as it is possible to remove penetrant from open defects.

(e) Prepare wet developer by mixing one pound of powder to four gallons of water 24 to 26.7 degrees C (75 to 80 degrees F).

(f) Apply a film of wet developer, over area to be inspected, by brushing, spraying or dipping.

NOTE: Avoid any accumulation of the developer in fillets or other areas, since it may dry to such a heavy coating that defects may be concealed.

(g) Air dry. Parts may be oven dried providing temperature does not exceed 121 degrees C (250 degrees F) and time in oven does not exceed three minutes. Overheating can evaporate penetrant from fine cracks.

(h) Allow to develop. Development time should be equal to one-half of penetration time.

(i) Inspect parts with a black light in a darkened area or booth. Defects will be shown by fluorescence of dye penetrant where it has developed out of flaws. Brightness and area of fluorescence will indicate relative depth of volume of defect. Cracks will show as fluorescent lines.

(4) Zyglo-Penetrex fluorescent dye penetrant-inspection.

(a) Procedure for use of Zyglo-Penetrex dye penetrant, specified in paragraph 6.C, is identical to that of Zyglo penetrant except that a film of emulsifier must be applied separately from penetrant. Apply emulsifier by brushing, spraying or dipping immediately after application of dye penetrant.

(5) Dy-Chek and Spot-Chek non-fluorescent dye penetrant inspection.

(a) Thoroughly clean area to be inspected by vapor degreasing or with aliphatic naphtha, specified in paragraph 6.C, and a clean, lint-free cloth. Allow part to dry.

(b) Apply film of penetrant specified in paragraph 6.C by brushing, spraying, or dipping, to area to be inspected. Allow to penetrate for a minimum time of three minutes.

(c) Remove all dye penetrant from surface of part with cleaner provided with dye penetrant kit.

(d) Allow part to dry.

(e) Apply film of dye developer, supplied with dye penetrant kit, over area to be inspected. Any defect will be clearly indicated by the colored dye on the white developer.

(f) Remove developer and any remaining dye with cleaner supplied in penetrant kit.

(6) Met-L-Chek non-fluorescent dye penetrant inspection.

(a) Procedure for use of Met-L-Chek dye penetrant specified in paragraph 6.C is identical to that of Dy-Chek and Spot-Chek, except that Met-L-Chek dye penetrant and developer may be removed with clear rinse water.

D. Magnetic Particle Inspection.

(1) Vapor degrease part.

(2) Mount part horizontally between contact plates.

CAUTION: INSURE THAT SURFACES OF CONTACT PLATES ARE CLEAN TO PREVENT BURNING CONTACT AREA.

(3) Pass DC current directly through longitudinal axis of part using 800 to 1200 amperes DC per inch of solid diameter.

(4) Spray or dust magnetic powder directly on surface of part while current is flowing.

(5) Distribute and remove excess powder by blowing lightly or by lightly tapping part.

NOTE: Care must be taken when blowing or tapping to avoid disturbing indications that may be present.

(6) With current flowing, accomplish the following:

(a) Carefully inspect pattern of powder to determine indications of discontinuity in magnetic field.

(b) Reject any part in which a crack or flaw is discovered as indicated by discontinuity in magnetic pattern.

(7) Demagnetize part.

E. Component Inspection.

IPC FIGURE & INDEX NO.	NOMENCLATURE	INSPECTION
1-9.-13	Upholstery Assembly	Visual-fabric for holes and wear. snaps for wear.
1-10.-11.-14.-15	Cushions and Filler	Visual-wear or damage.
1-48	Index Pin Spring	Free length-1.625 inches 2-pound load 1.25 inches 4-pound load-0.90 inches Visual-corrosion and distortion.
1-51	Index Pin	Visual-stripped or damaged threads, wear.
1-67	Armrest Fairing	Visual-enlarged or cracked holes.
1-71	Bracket Assy	Visual-all components for damage or wear.
1-73	Fairing Assemblies	Visual-damage, wear and cracked & loose rivets.
1-42	Safety Belt	Visual-damage or wear at attaching points. frayed edges and breaks in fabric. buckle for ease of operation and tight locking.
1-83	Swivel Control Handle	Visual-damage. cracks and wear.
1-79	Swivel Control Tube	Visual-damage. cracks and wear.
1-88	Control Clevis	Visual-damage or wear. stripped or damaged threads.
1-112	Swivel Cable Assembly	Visual-kinks and cover wear, cable shall travel freely in cover.

IPC FIGURE & INDEX NO.	NOMENCLATURE	INSPECTION
1-111	Index Pin Spring	Free length -1.60 inches 3/4-pound load-1.44 inches 2-pound load-1.24 inches Visual-corrosion, distortion.
1-110	Index Pin	Visual-threads and pin points for damage and wear. Pin point diameter-0.248-0.249.
1-93	Horizontal Control Handle	Visual-damage, cracks and wear.
1-98	Control Clevis	Visual-damage and wear stripped or worn threads.
1-120	Horizontal Cable Assembly	Visual-kinks and cover wear, cable shall travel freely in cover.
1-99	Handle Spacer Spring	Visual-corrosion and distortion.
1-100	Vertical Control Handle	Visual-damage, cracks and wear.
1-109	Vertical Control Clevis	Visual-damage and wear, stripped or worn threads.
1-129	Vertical Cable Assembly	Visual-kinks and cover wear, cable shall travel freely in cover.
1-128	Spring	Visual-corrosion and distortion.
1-20	Inertia Reel Spring	Free length-2.625 inches 2-pound load-1.50 inches 4-pound load-0.88 inches Visual-corrosion and distortion.
1-1	Inertia Reel and Shoulder Harness	Visual-damage and wear, shoulder harness for damage and wear at attaching points, frayed edges and breaks in fabric.

IPC FIGURE & INDEX NO.	NOMENCLATURE	INSPECTION
1-21	Inertia Reel Clevis	Visual-damage and wear, stripped or worn threads.
1-133	Upper Structure	Visual-damage, wear, cracks, dents, cracked or sheared rivets.
1-134	Roller	Visual-damage and wear.
1-162.-163	Fairings	Visual-dents, cracks, scratches.
1-237	Gripper	Visual-damage and wear.
1-248	Bushing	Visual-damage and wear.
1-242	Roller	Visual-damage and wear.
1-176	Vertical and Swivel Control Assembly	Visual-damage and wear.
	Index Pin	Visual-damage and wear.
1-231	Truck Lock Pin	Visual-damage and wear.
1-232	Block	Visual-damage and wear.
1-230	Bushing	Visual-damage and wear.
1-184	Set Screw	Visual-damage and wear.
1-220	Load Spring	Visual-corrosion and distortion.

F. Special Components Inspection.

IPC FIGURE & INDEX NO.	NOMENCLATURE	INSPECTION
1-25	Inertia Control Rod Assy	Dye penetrant; refer to paragraph 4.C.
1-32	Crank Assembly	Dye penetrant; refer to paragraph 4.C.
1-33	Rod Assembly	Dye penetrant; refer to paragraph 4.C.
1-34	Link Assembly	Dye penetrant; refer to paragraph 4.C.
1-51	Pin	Magnetic particle; refer to paragraph 4.D.
1-72	Spindle Guide	Dye penetrant; refer to paragraph 4.C.
1-137	Bolt	Magnetic particle; refer to paragraph 4.D.
1-185	Bell Crank Assy	Dye penetrant; refer to paragraph 4.C.
1-211	Bell Crank Assy	Dye penetrant; refer to paragraph 4.C.
1-215	Bell Crank Assy	Dye penetrant; refer to paragraph 4.C.

5. Repair

Following cleaning and inspection, components not meeting standards or those having faults described in the inspection section must be repaired before the seat is returned to service or storage. Repairs are listed in the following table. Components not listed in this table, but covered in inspection should be replaced if worn.

COMPONENTS	REPAIR
A. Upholstery Assemblies	Repair as needed.
B. Base Fairings and Visible Structural Members	Repaint as needed.
C. Rivets	Replace cracked or sheared rivets.
D. Bolts, screws, nuts with damaged threads.	Replace.

6. Assembly

A. General.

Assemble components of the flight engineer's seat after cleaning, inspection and repair. Numbers following part names refer to index numbers in the illustrated parts catalog (IPC).

B. Assembly Procedure.

NOTE: Lubricate all bearing surfaces and moving parts with dry lubricant before assembly.

(1) Gripper Assemblies.

(a) (See IPC Figure 1.) Insert bushings (248) into roller (242). With one spacer (245) at either end of bushing and roller, slide parts into gripper (249) and lock in place with bolt (246), woodruff key (247), washer (244) and nut (243).

(b) Insert bushing (241) into gripper (249) and lock in place with screw (240), washer (239) and nut (238).

(c) Attach gripper assemblies to base assembly (174) with two bolts (175) in each gripper assembly.

NOTE: When seat is re-installed, adjust cam bushing (248) so roller (242) fits track.

(2) Horizontal Control Assembly.

(a) Looking forward from rear of seat, insert two bushings (219) in brackets on base assembly (174). Insert tube (226) from left to right through bellcrank assemblies (211) and (215), bracket, spring (220), bracket and bellcrank assembly (211). Insure long loop of spring is to right adjacent to bracket.

(b) Secure each bellcrank assembly (211) with two screws (214), two washers (213) and two nuts (212). Secure bellcrank assembly (215) with two screws (218), washers (217) and nuts (216). Secure spring (220) to tube (226) using screw (224), washer (222) and nut (221), and to bracket using screw (225), washer (223) and nut (221).

(c) Insert bushing (209) in support (205) and slide bushing over end of tube (226). Secure support to base assembly (174) using screw (208), washer (207), nut (206) and one rivet. Repeat procedure for opposite end of tube.

(3) Base Assembly.

(a) Install two blocks (232) into spreader of base assembly with two screws (235), two screws (208), washers (234) and nuts (233).

(b) Attach two track lock assembly pin assemblies (231) to two bellcrank assemblies (211) with pins (229), washers (228) and cotter pins (227).

(c) Install bellcrank assembly (185) in bracket on swivel sub-assembly with pin (191), washer (190) and cotter pin (189).

(d) Attach index pin (191) to bellcrank assembly (185) by inserting pin into indexing hole in swivel sub-assembly and securing pin to bellcrank upper arm with pin (188), washer (187) and cotter pin (186).

(e) Attach vertical and swivel control assembly (176) to base assembly (174) with two bolts (182), washers (180), nuts (178), six bolts (181), washers (179) and nuts (177). Turn swivel assembly to gain access to screw holes.

(f) Assemble two bushings (200) to swivel sub-assembly with two screws (199), washers (198) and nuts (197).

(4) Install spring (172) and spring disc (173) in tube (167) and attach upper structure assembly (133) to base assembly (174) with locknut (183) and set screw (184).

NOTE: If upper structure components (143) through (171) were disassembled for repair, they must be assembled before performing step 6.B. (4).

(5) Install seat spacer (141), nut (139), washer (140) and stud (142).

(6) Install grommet (138) and attach seat roller (134) to upper structure assembly (133) with bolt (137), washer (136) and nut (135).

(7) Vertical Control.

(a) Install spring (128) and attach clevis (127) to vertical cable assembly (129). Tighten nuts on cable assembly to secure attachment.

(b) Attach clevis (127) to bellcrank assembly (185) with pin (125), washer (126) and cotter pin (124).

(c) Attach vertical cable assembly (129) to upper structure assembly with bolt (132), washer (131) and nut (130).

(d) Connect clevis (109) to vertical cable assembly (129) with nut (106).

(e) Connect vertical control clevis (109) to bellcrank assembly (104) with pin (108), washer (107) and cotter pin (105).

(8) Horizontal Control.

(a) Attach clevis (119) to horizontal cable assembly (120) and tighten nuts on cable assembly to lock clevis in place.

(b) Connect clevis (119) to horizontal control assembly bellcrank (215) with pin (117), washer (118) and cotter pin (116).

(c) Attach horizontal cable assembly (120) to upper structure assembly with bolt (123), washer (122) and nut (121).

(d) Attach clevis (98) to horizontal cable assembly (120) with nut (95).

(e) Connect clevis (98) to horizontal control handle (93) with pin (97), washer (96) and cotter pin (94).

(9) Horizontal and Vertical Control Handles.

(a) Insert two bushings (159) into tube mount brackets on upper structure assembly.

(b) Slide tube (92) through mount bracket toward front of seat, then through vertical control handle (100), spring (99) and horizontal control handle (93).

(c) Attach bellcrank assembly (104) to tube (92). Bellcrank should protrude toward the rear of seat assembly. Secure bellcrank with screw (91), washer (90) and nut (89).

(d) Attach vertical control handle (100) to tube (92) with screw (103), washer (102) and nut (101).

(10) Swivel Control.

(a) Attach spring (111) and index pin (110) to swivel cable assembly (112) with nuts on cable assembly.

(b) Attach swivel cable assembly (112) to upper structure assembly with bolt (115), washer (114) and nut (113).

(c) Attach control clevis (88) to swivel cable assembly (112) with nut (85) and to swivel control handle (83) with pin (87), washer (86) and cotter pin (84).

(d) Attach swivel control handle (83) in place on upper structure assembly by sliding tube (79) through control handle and between brackets on the upper structure. Secure tube with screw (77) and bolt (78).

(11) Install base fairing assemblies (73) with four screws (76) at the base and four screws (75) and nuts (74) in overlap.

(12) Armrests.

(a) Slide armrest adjustment spindle (68) on armrest adjustment spindle guide (72).

(b) Attach armrest fairing bracket assembly (58) and armrest adjustment spindle guide (72) to seat frame with two screws (69) and washers (70).

(c) Replace armrest upholstery (54) and cushion assembly (55) on shell assembly (64), if these assemblies were removed for repair or replacement.

(d) Attach armrest fairing (67) with eight screws (66).

(e) Install index pin spring (48) and index pin (51) in index cup (49) and secure by screwing armrest vertical adjustment button (47) on index pin (51) and turning button clockwise while holding index pin.

(f) Hold armrest in vertical position and slide armrest over armrest adjustment spindle (68).

(13) Attach safety belt (42) with two screws (45), washers (44) and nuts (43).

(14) Attach bezel (37) to left-hand upper seat fairing assembly (40) and snap both left- and right-hand fairing assemblies in place.

(15) Inertia Reel Control.

(a) Install nut (38) and spring (39) on rod assembly (33).

(b) Attach rod assembly (33) and two crank assemblies (32) to link assembly (34) with three cotter pins (29), washers (30) and pins (31).

(c) Attach inertia reel control assembly (26) to reel and shoulder harness assembly (1) with washer (27) and pin (28).

(d) Screw clevis (21) on inertia control rod assembly (25) and attach rod assembly (25) and inertia control rod assembly (26) to reel assembly (1) with cotter pin (22), washer (23) and pin (24).

(e) Attach spring (20) and spacer (19) with pin (18).

(f) Attach clevis (21), spacer (17) and spring (20) with pin (16).

(16) Install cushion assembly (14) and filler (15) if they were removed, and snap seat bottom upholstery assembly (13) and muslin cover (12) in place on seat assembly.

(17) Install cushion assembly (10) and filler (11) if they were removed, and snap seat back upholstery assembly (9) and back muslin cover (8) in place on seat assembly.

(18) Attach reel and shoulder harness (1) to seat by lifting seat back upholstery assembly and installing four nuts (2), one washer (3), three washers (4), one bolt (5), two bolts (6) and one bolt (7).

C. Materials.

Use materials recommended or equivalent.

MATERIAL	IDENTIFICATION	SOURCE
(1) Dry lubricant	Molycote M-88	Alpha Corporation, Greenwich, Conn.
(2) Cleaning solvent	Federal Specification P-S-661	Optional
(3) Cement	EC-1099	3-M Corporation, St. Paul, Minnesota
(4) Upholstery, covers	Travair Nylon Cord	Collins & Aikman Corp. 210 Madison Avenue, New York 16, New York
(5) Aliphatic naphtha	TT-N-95A	Optional
(6) Dye penetrant cleaner, developer	Zyglo	Magnaflux Corporation, 7300 W. Lawrence Ave., Chicago 1, Illinois
(7) Dye penetrant cleaner, developer	Zyglo-Penetrex	Magnaflux Corporation, 7300 W. Lawrence Ave., Chicago 1, Illinois
(8) Dye penetrant cleaner, developer	Dy-Chek	Turco Manufacturing Co., Terminal Annex 2649, Los Angeles 54, California
(9) Dye penetrant cleaner, developer	Spot-Chek	Turco Manufacturing Co., Terminal Annex 2649, Los Angeles 54, California
(10) Dye penetrant cleaner, developer	Met-L-Chek	Bailey Equipment Co., 3856 California St., San Diego 1, California
(11) Wrapping paper	Federal Specification UU-P-271	Optional

7. Fits and Clearances

This section is not applicable to this assembly.

8. Testing

A. General.

Tests made on the flight engineer's seat after assembly consist of checking operation of adjustable armrests; the vertical, horizontal and swivel adjustment systems; and the inertia reel and belt assemblies.

B. Testing Procedures (see IPC Figure 1).

TEST STEPS	KEY ITEMS
(1) Armrest Installations.	
(a) Press vertical adjustment index button (47) and move armrest up and down.	Armrest should move freely without binding.
(b) Press vertical adjustment button (47) and move armrest to top position. Release button.	Armrest should hold firmly in top position.
(c) Press vertical adjustment button (47) and move armrest progressively lower hole by hole. Release button at each hole location.	Armrest should hold firmly in each position.
(d) Rotate armrest to vertical position.	Armrest should turn without binding.
(2) Vertical Adjustment System.	
(a) Lift vertical control handle (100) and raise seat to highest point. Release handle.	Controls and seat should operate easily and seat should hold firmly in topmost position.
(b) Lift vertical control handle (100) and drop seat to second index hole. Repeat step for all index holes.	Seat should hold firmly in each position.
(3) Horizontal Adjustment System.	
(a) Lift horizontal control handle (93) to activate horizontal control assembly. Hold handle up during test.	Controls should operate easily and seat should slide freely forward and back on track.

TEST STEPS	KEY ITEMS
(b) Lift horizontal control handle (93) and move seat to far back position. Release handle.	Seat should hold firmly in back position.
(c) Lift horizontal control handle (93) and move seat forward a short distance. Release handle.	Seat should hold firmly in position.
(d) Repeat step (c) through several seat positions.	Seat should hold firmly in all positions.
(4) Swivel Adjustment System.	
(a) Lift swivel control handle (83) to release index pin (47). Turn seat.	Seat should turn freely in both directions. Controls should operate freely.
(b) Lift swivel control handle (83) and move seat to far left position. Release handle.	Seat should lock in position.
(c) Lift swivel control handle (83) and move seat to first position to right. Release handle. Repeat step through each position.	Seat should lock in position.
(d) Lock seat in any position and try moving seat from side to side.	There should be no swivel motion.
(5) Inertia Reel.	
(a) Press inertia reel button (35), release button and pull shoulder straps.	Straps should pull freely.
(b) Release inertia reel button (35), release button and give shoulder straps quick pull.	Straps should hold firmly.
(c) Repeat step (b) with shoulder straps extended to different lenghts.	Straps should hold firmly.

TEST STEPS	KEY ITEMS
(6) Belt Assembly (42).	
(a) Lock all parts of belt assembly in buckle-lock.	Lock should hold belts securely.
(b) Release lock.	Shoulder straps, crotch straps and one side of belt should release easily.

9. Trouble Shooting

A. General.

Trouble shooting for the flight engineer's seat concerns only the armrest assemblies; the vertical, horizontal and swivel controls; the inertia reel and control assembly; and the belt assembly.

B. Trouble Shooting Procedures (see IPC Figure 1).

CONDITION	PROBABLE CAUSE & CORRECTION
(1) Armrest Installations	
(a) Armrest vertical adjustment index button (47) does not depress.	Armrest index pin spring (48) is binding. Unscrew button and free spring.
(b) Armrest binds when vertical adjustment button (47) is depressed and armrest is moved up and down.	Armrest adjustment spindle (68) is worn. Replace spindle.
	Armrest adjustment spindle guide (72) is worn or torqued. Replace guide.
	Mounting tubes on seat frame for spindle guide (72) are out of alignment. Realign tubes.
(c) Armrest will not hold firmly in position.	Index pin (51) is worn. Replace pin.
	Holes in armrest spindle guide (72) are worn. Replace guide.
	Index pin spring (48) is weak. Replace spring.
(d) Armrest will not turn to vertical or will not hold on armrest spindle (68).	Hinge (59) in bracket assembly (58) is not in place. Press armrest firmly on seat or shorten hinge.

CONDITION	PROBABLE CAUSE & CORRECTION
(2) Vertical Adjustment System	
(a) Vertical control handle (100) binds.	Tube (92) is worn. Replace tube. Check bearing in brackets on seat frame for wear. If bearings are worn, replace.
	Spring (99) is binding. Check spring for wear. If worn, replace.
(b) Vertical adjustment system binds.	Check all components of system for wear at point of attachment. If parts are worn, replace.
(c) Vertical cable assembly (129) binds.	Cable is kinked or damaged. If damaged, replace.
(d) Seat does not hold firmly in adjusted position.	Index pin (192) is worn. Replace pin.
	Spring (128) is worn. Replace spring.
(3) Horizontal Adjustment System	
(a) Horizontal control handle (93) binds.	Tube (92) is worn. Replace tube.
	Spring (99) is binding. Check spring for wear. If worn, replace.
(b) Horizontal adjustment system binds.	Check all components of system for wear at point of attachment. If parts are worn, replace.
(c) Horizontal cable assembly (120) binds.	Cable is kinked or damaged. Replace cable if damaged.
(d) Seat does not hold firmly in adjusted position.	Track lock pin (231) is worn. Replace pin.
	Load spring (220) is weak. Replace spring.

CONDITION	PROBABLE CAUSE & CORRECTION
(c) Seat does not move freely forward and back on track.	Gripper assemblies are worn. Replace assemblies or components as needed.
	Springs are weak and do not allow track lock pin (231) to retract. Replace springs.
	Rollers are not adjusted to track. Loosen bolt (246) and adjust cam bushing (248) until rollers seat on track.
(4) Swivel Adjustment System	
(a) Swivel control handle (83) binds.	Swivel control handle (83) is worn. Replace handle.
	Tube (82) is worn. Replace tube.
(b) Swivel adjustment system binds.	Check all components of system for wear at point of attachment. If parts are worn, replace.
(c) Swivel cable assembly (112) binds.	Cable is kinked or damaged. Replace cable if damaged.
(d) Seat does not hold in swiveled position.	Index pin (110) is worn. Replace pin.
	Index pin spring (111) is weak. Replace spring.
(e) Seat swivels when locked in position.	Set screw (184) is worn. Replace screw.
(5) Inertia Reel and Control System	
(a) Inertia reel does not hold against pull on straps.	Inertia reel faulty. Replace reel and shoulder harness (1).

	CONDITION	PROBABLE CAUSE & CORRECTION
(a)	Inertia reel does not hold against pull on straps. (Continued)	Spring (20) is weak. Replace spring.
		Button (35) is binding.
		Linkage is binding.
(b)	Inertia reel binds when inertia reel button (35) is depressed then released.	Spring (39) is weak. Replace spring.
		Inertia reel control assembly is binding. Check components (16 through 39) for wear and damage. If components are worn or damaged, replace.
		Inertia reel is faulty. Replace reel and shoulder harness (1).
(c)	Pressure on inertia reel button (35) does not release inertia reel.	Spring (39) is weak. Replace spring.
		Components of inertia reel control assembly are binding. Check components (16 through 39) for wear and damage. Replace components if worn or damaged.
		Spring (20) is weak. Replace spring.

(6) Belt Assembly (42)

(a)	Belt buckle-lock does not hold belt, crotch strap and shoulder straps firmly.	Buckle-lock is faulty. Replace belt assembly.
(b)	Buckle-lock does not release belt, crotch strap and shoulder straps.	Buckle-lock is faulty. Replace belt assembly.

10. Storage Instructions

A. The seat assembly is essentially corrosion resistant and no special preservation is required.

B. Wrap seat in waterproof wrapping paper specified in paragraph 6.C.(15), or a plastic cover. Use tape specified in paragraph 6.C.(16), or equivalent, to secure wrapping paper, or cover. Stamp seat assembly part number and date of overhaul on a tag, or in a convenient location on seat wrapper.

C. Store seat in a cool dry area, below 68 degrees F, away from sunlight and heat source.

11. Special Tools, Fixtures and Equipment

No special tools, fixtures or equipment are needed for overhaul of the flight engineer's seat.

ILLUSTRATED PARTS BREAKDOWN

FLIGHT ENGINEER'S SEAT
(Convair Part No. 22-98505-3)

ATA NO. 25-1-2

Applicable to Models 30-6 and 30-8 Oct. 10/62

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AN315-3R		1 -106	1
AN316-6R		1 -183	1
AN340-8		1 -38	1
AN365-1032		1 -149	4
AN380-2-1		1 -22	1
AN380-2-1		1 -29	3
AN380-2-1		1 -41	1
AN380-2-1		1 -84	1
AN380-2-1		1 -94	1
AN380-2-1		1 -105	1
AN380-2-1		1 -116	1
AN380-2-1		1 -124	1
AN380-2-1		1 -186	1
AN380-2-1		1 -189	1
AN380-2-1		1 -227	2
AN4-4A		1 -115	1
AN4-4A		1 -123	1
AN4-4A		1 -132	1
AN525-10R6		1 -77	1
AN530-10-6		1 -75	4
AN935-10		1 -70	2
AN960-10		1 -3	1
AN960-10		1 -44	2
AN960-10		1 -136	1
AN960-10		1 -150	2
AN960-10		1 -207	2
AN960-10		1 -222	1
AN960-10		1 -234	2
AN960-10L		1 -4	3
AN960-10L		1 -102	1
AN960-10L		1 -151	2
AN960-10L		1 -187	1
AN960-10L		1 -198	2
AN960-10L		1 -223	1
AN960-4		1 -23	1
AN960-4		1 -27	2
AN960-4		1 -30	3
AN960-4		1 -86	1
AN960-4		1 -96	1
AN960-4		1 -107	1
AN960-4		1 -118	1
AN960-4		1 -126	1
AN960-4		1 -190	1
AN960-4		1 -228	2
AN960-416		1 -114	1
AN960-416		1 -122	1
AN960-416		1 -131	1
AN960-416L		1 -179	6
AN960-416L		1 -239	1
AN960-416L		1 -244	1
AN960-616L		1 -180	2
AN960-8		1 -140	2
AN960-8		1 -156	4
AN960-8L		1 -90	1
AN960-8L		1 -213	4
AN960-8L		1 -217	2
C1350-1021		1 -74	4
C1583-012-1D		1 -36	1
HS2R7C6-3		1 -194	18
KR5-1		1 -80	2
L335-1-5		1 -81	2
MS20001-8-200		1 -	REF
MS20392-1-12		1 -191	1

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
MS20392-1-13		1 -108	1
MS20392-1-13		1 -117	1
MS20392-1-13		1 -125	1
MS20392-1-13		1 -229	2
MS20392-1-19		1 -28	2
MS20392-1-19		1 -87	1
MS20392-1-19		1 -97	1
MS20392-1-23		1 -18	1
MS20392-1-7		1 -24	1
MS20392-1-7		1 -31	3
MS20392-2-17		1 -16	1
MS20392-2-43		1 -188	1
MS20600B4-2		1 -144	175
NAS1103-34		1 -7	1
NAS1103-4		1 -5	1
NAS1103-5		1 -6	2
NAS1103-8		1 -169	6
NAS1104-5		1 -175	8
NAS1204-6		1 -181	6
NAS1206-8		1 -182	2
NAS179-6		1 -195	18
NAS42DD4-8		1 -19	1
NAS42DD6-8		1 -17	1
NAS43-3-35		1 -157	4
NAS43HT7-3		1 -245	2
NAS623-2-10		1 -91	1
NAS623-2-10		1 -214	4
NAS623-2-10		1 -218	2
NAS623-2-13		1 -158	4
NAS623-2-2		1 -66	8
NAS623-3-13		1 -103	1
NAS623-3-16		1 -45	2
NAS623-3-21		1 -235	2
NAS623-3-22		1 -208	2
NAS623-3-3		1 -152	2
NAS623-3-3		1 -224	1
NAS623-3-4		1 -69	2
NAS623-3-4		1 -153	2
NAS623-3-6		1 -199	2
NAS623-3-8		1 -76	4
NAS623-3-9		1 -225	1
NAS623-4-19		1 -240	1
NAS679A08		1 -89	1
NAS679A08		1 -139	2
NAS679A08		1 -155	4
NAS679A08		1 -212	4
NAS679A08		1 -216	2
NAS679A3		1 -2	4
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NAS679A3		1 -197	2
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NAS679A3		1 -221	2
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NAS679A4		1 -130	1
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NAS679A4		1 -238	1
NAS679A4		1 -243	1
NAS679A6		1 -178	2
NAS75-4-104		1 -241	1
NAS77A4-72P		1 -230	2
NAS77A8-09P		1 -159	2
NAS77A8-09P		1 -209	2
NAS77A8-12P		1 -219	2
0101146-0		1 -1	1
01101115-0		1 -42	1
01101116-0		1 -42	1
22-98350		1 -	REF

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
22-98350-1		1 -92	1
22-98351		1 -79	1
22-98351-7		1 -82	1
22-98354		1 -104	1
22-98357		1 -9	1
22-98362-7		1 -246	1
22-98363-1		1 -12	1
22-98366		1 -8	1
22-98367		1 -21	1
22-98368		1 -110	1
22-98371-2		1 -220	1
22-98373		1 -60	1
22-98374		1 -48	1
22-98375		1 -172	1
22-98376		1 -39	1
22-98378		1 -99	1
22-98379		1 -20	1
22-98380		1 -111	1
22-98505-3		1 -	REF
22-98508		1 -203	2
22-98509-1		1 -174	1
22-98509-11		1 -205	2
22-98509-13		1 -232	2
22-98509-19		1 -236	1
22-98509-20		1 -	1
22-98510-3		1 -165	1
22-98511-7		1 -73	1
22-98511-9		1 -	1
22-98512-1		1 -40	1
22-98512-2		1 -	1
22-98513-10		1 -63	1
22-98513-13		1 -154	1
22-98513-43		1 -141	2
22-98513-43		1 -147	4
22-98513-9		1 -162	1
22-98517-11		1 -161	1
22-98517-19		1 -148	1
22-98517-45		1 -138	1
22-98517-1		1 -133	1
22-98517-7		1 -164	1
22-98517-9		1 -160	1
22-98518-3		1 -166	1
22-98518-49		1 -167	1
22-98518-7		1 -171	1
22-98519-1		1 -176	1
22-98519-19		1 -	REF
22-98519-21		1 -202	1
22-98519-23		2 -201	1
22-98519-25		1 -184	1
22-98519-27		1 -200	2
22-98519-29		1 -192	1
22-98519-47		1 -185	1
22-98519-7		1 -193	1
22-98519-9		1 -196	1
22-98522		1 -14	1
22-98523		1 -15	1
22-98524-1		1 -10	1
22-98525		1 -11	1
22-98527		1 -13	1
22-98528		1 -37	1
22-98529		1 -204	1
22-98530-55		1 -134	1
22-98544		1 -56	1
22-98547		1 -	REF
22-98548-7		1 -83	1

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
22-98549		1 -93	1
22-98550		1 -100	1
22-98551		1 -52	1
22-98552-7		1 -53	1
22-98552-8		1 -	1
22-98560		1 -242	1
22-98562-1		1 -	1
22-98562-2		1 -	1
22-98562-7		1 -46	1
22-98562-8		1 -	1
22-98563-1		1 -64	1
22-98563-2		1 -	1
22-98564-1		1 -68	1
22-98564-2		1 -	1
22-98565-10		1 -	1
22-98565-13		1 -63	1
22-98565-14		1 -	1
22-98565-21		1 -62	1
22-98565-3		1 -58	1
22-98565-4		1 -	1
22-98565-9		1 -	1
22-98566		1 -	1
22-98566-1		1 -51	1
22-98566-3		1 -50	1
22-98567-1		1 -145	1
22-98567-2		1 -	1
22-98568		1 -47	1
22-98570		1 -57	1
22-98573-9		1 -72	1
22-98576-3		1 -55	1
22-98576-4		1 -	1
22-98577		1 -54	1
22-98578		1 -170	1
22-98579-1		1 -67	1
22-98580		1 -49	1
22-98581		1 -59	1
22-98581-7		1 -61	1
22-98582		1 -71	1
22-98583		1 -210	1
22-98583-19		1 -226	1
22-98583-7		1 -211	2
22-98583-9		1 -215	1
22-98592-3		1 -237	2
22-98592-4		1 -	2
22-98592-7		1 -249	1
22-98592-8		1 -	1
22-98592-9		1 -248	1
22-98593		1 -35	1
22-98595		1 -88	1
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22-98595		1 -127	1
22-98596		1 -173	2
22-98598-1		1 -26	1
22-98598-11		1 -34	1
22-98598-13		1 -25	1
22-98598-7		1 -32	2
22-98598-9		1 -33	1
22-98609-7		1 -231	2
40433-6		1 -112	1
40433-6		1 -129	1
40433-7		1 -120	1
630B10022		1 -128	1
91-63000-002 (See MS20600B4-2)			

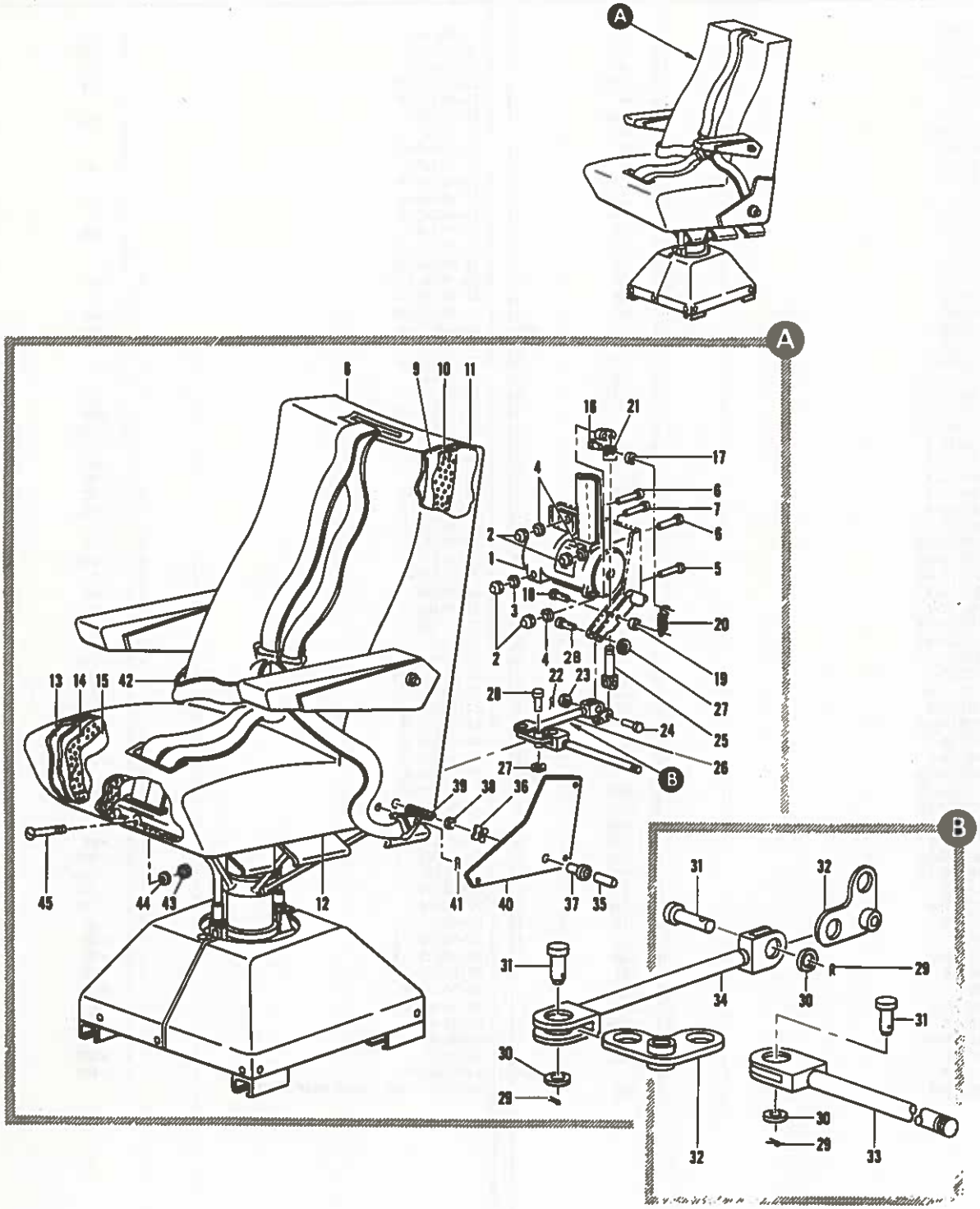

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1-	22-98505-3	SEAT ASSEMBLY, FLIGHT ENGINEER		1		REF
-1	0101146-0	. REEL AND SHOULDER HARNESS, -V45402-		1		1
		ATTACHING PARTS				
-2	NAS679A3	. NUT		1		4
-3	AN960-10	. WASHER		1		1
-4	AN960-10L	. WASHER		1		3
-5	NAS1103-4	. BOLT		1		1
-6	NAS1103-5	. BOLT		1		2
-7	NAS1103-34	. BOLT		1		1
		----X----				
-8	22-98366	. COVER, SEAT BACK		1		1
-9	22-98357-3	. UPHOLSTERY ASSEMBLY, SEAT BACK STITCHED		1		1
-10	22-98524-1	. CUSHION ASSEMBLY, SEAT BACK BONDED		1		1
-11	22-98525	. FILLER, SEAT BACK		1		1
-12	22-98363-1	. COVER ASSEMBLY, SEAT BOTTOM STITCHED		1		1
-13	22-98527	. UPHOLSTERY ASSEMBLY, SEAT BOTTOM STITCHED		1		1
-14	22-98522	. CUSHION ASSEMBLY, SEAT BOTTOM BONDED		1		1
-15	22-98523	. FILLER, SEAT BOTTOM		1		1
-16	MS20392-2-17	. PIN		1		1
-17	NAS42DD6-8	. SPACER		1		1
-18	MS20392-1-23	. PIN		1		1
-19	NAS42DD4-8	. SPACER		1		1
-20	22-98379	. SPRING, INERTIA REEL		1		1
-21	22-98367	. CLEVIS, INERTIA REEL		1		1
-22	AN380-2-1	. PIN, COTTER		1		1
-23	AN960-4	. WASHER		1		1
-24	MS20392-1-7	. PIN		1		1
-25	22-98598-13	. ROD ASSEMBLY, INERTIA CONTROL WELDED		1		1
-26	22-98598-1	. CONTROL ASSEMBLY, INERTIA REEL		1		1
		ATTACHING PARTS				
-27	AN960-4	. WASHER		1		2
-28	MS20392-1-19	. PIN		1		2
		----X----				
-29	AN380-2-1	. . PIN, COTTER		1		3
-30	AN960-4	. . WASHER		1		3
-31	MS20392-1-7	. . PIN		1		3
-32	22-98598-7	. . CRANK ASSEMBLY, WELDED		1		2
-33	22-98598-9	. . ROD ASSEMBLY, WELDED		1		1
-34	22-98598-11	. . LINK ASSEMBLY, WELDED		1		1
-35	22-98593	. BUTTON, INERTIA REEL CONTROL		1		1
-36	C1583-012-1D	. SPEEDNUT, -V78553-		1		1
-37	22-98528	. BEZEL, INERTIA REEL CONTROL		1		1
-38	AN340-8	. NUT		1		1
-39	22-98376	. SPRING		1		1
-40	22-98512-1	. FAIRING ASSEMBLY, SEAT UPPER LH RIVETED		1		1
	22-98512-2	. FAIRING ASSEMBLY, SEAT UPPER RH RIVETED		1		1
-41	AN380-2-1	. PIN, COTTER		1		1
-42	01101115-0	. BELT, SAFETY -V45402-		1		1
		ATTACHING PARTS				
-43	NAS679A3	. NUT		1		2
-44	AN960-10	. WASHER		1		2
-45	NAS623-3-16	. SCREW		1		2
		----X----				

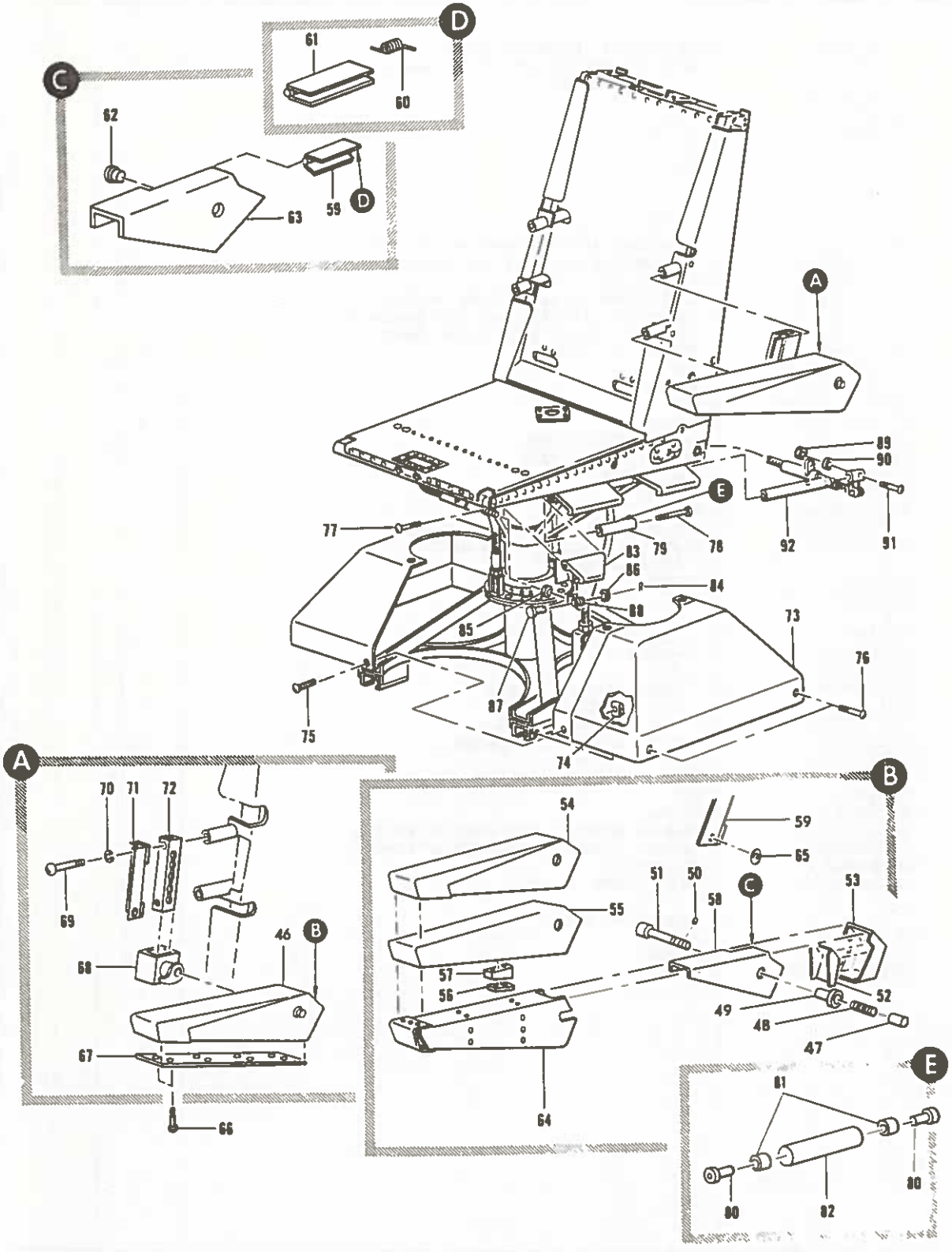

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1-	22-98562-1	. ARMREST INSTALLATION, SEAT LH		1		1
	22-98562-2	. ARMREST INSTALLATION, SEAT RH		1		1
-46	22-98562-7	. . ARMREST ASSEMBLY, LH		1		1
	22-98562-8	. . ARMREST ASSEMBLY, RH		1		1
-47	22-98568	. . . BUTTON, INDEX		1		1
-48	22-98374	. . . SPRING, INDEX		1		1
-49	22-98580	. . . CUP, INDEX		1		1
	22-98566	. . . PIN ASSEMBLY, INDEX		1		1
-50	22-98566-3	. . . . INSERT, NYLOCK		1		1
-51	22-98566-1	. . . . PIN		1		1
-52	22-98551	. . . BLOCK, SUPPORT		1		1
-53	22-98552-7	. . . CAP, LH		1		1
	22-98552-8	. . . CAP, RH		1		1
-54	22-98577	. . . UPHOLSTERY ASSEMBLY, STITCHED		1		1
-55	22-98576-3	. . . CUSHION ASSEMBLY, LH BONDED		1		1
	22-98576-4	. . . CUSHION ASSEMBLY, RH BONDED		1		1
-56	22-98544	. . . PLATE		1		1
-57	22-98570	. . . BLOCK		1		1
-58	22-98565-3	. . . BRACKET ASSEMBLY, LH		1		1
	22-98565-4	. . . BRACKET ASSEMBLY, RH		1		1
-59	22-98581	. . . . HINGE ASSEMBLY, ARMREST		1		1
-60	22-98373	. . . . . SPRING		1		1
-61	22-98581-7	. . . . . HINGE, MAKE FROM MS20001-8-200		1		1
	MS20001-8-200	. . . . . HINGE		1		REF
	22-98565-9	. . . . SUPPORT ASSEMBLY, LH		1		1
	22-98565-10	. . . . SUPPORT ASSEMBLY, RH		1		1
-62	22-98565-21	. . . . . BUSHING		1		1
-63	22-98565-13	. . . . . SUPPORT, LH		1		1
	22-98565-14	. . . . . SUPPORT, RH		1		1
-64	22-98563-1	. . . SHELL ASSEMBLY, LH WELDED		1		1
	22-98563-2	. . . SHELL ASSEMBLY, RH WELDED		1		1
-65	AN227-8	. . . STUD		1		1
-66	NAS623-2-2	. . . SCREW		1		8
-67	22-98579-1	. . FAIRING		1		1
-68	22-98564-1	. . SPINDLE, LH		1		1
	22-98564-2	. . SPINDLE, RH		1		1
-69	NAS623-3-4	. . SCREW		1		2
-70	AN935-10	. . WASHER		1		2
-71	22-98582	. . BRACKET ASSEMBLY, FAIRING RIVETED		1		1
-72	22-98573-9	. . GUIDE, SPINDLE		1		1
-73	22-98511-7	. FAIRING ASSEMBLY, SEAT BASE LH BONDED		1		1
	22-98511-9	. FAIRING ASSEMBLY, SEAT BASE RH BONDED		1		1
		ATTACHING PARTS				
-74	C1350-10Z1	. NUT, -V78553-		1		4
-75	AN530-10-6	. SCREW		1		4
-76	NAS623-3-8	. SCREW		1		4
		----X----				
-77	AN525-10R6	. SCREW		1		1
-78	AN3-3A	. BOLT		1		1
-79	22-98351	. TUBE ASSEMBLY		1		1
-80	KR5-1	. . KEY, -V99057-		1		2
-81	L335-1-5	. . INSERT, -V99057-		1		2
-82	22-98351-7	. . TUBE		1		1
-83	22-98548-7	. HANDLE, SWIVEL CONTROL MAKE FROM 22-98547		1		1
	22-98547	HANDLE		1		REF
		ATTACHING PARTS				
-84	AN380-2-1	. PIN, COTTER		1		1
-85	AN315-3R	. NUT		1		1
-86	AN960-4	. WASHER		1		1
-87	MS20392-1-19	. PIN		1		1
		----X----				
-88	22-98595	. CLEVIS		1		1
-89	NAS679A08	. NUT		1		1
-90	AN960-8L	. WASHER		1		1
-91	NAS623-2-10	. SCREW		1		1
-92	22-98350-1	. TUBE, HORIZONTAL CONTROL		1		1
	22-98350	. TUBE, HORIZONTAL CONTROL		1		REF
		ALT-INTCHG WITH 22-98350-1				

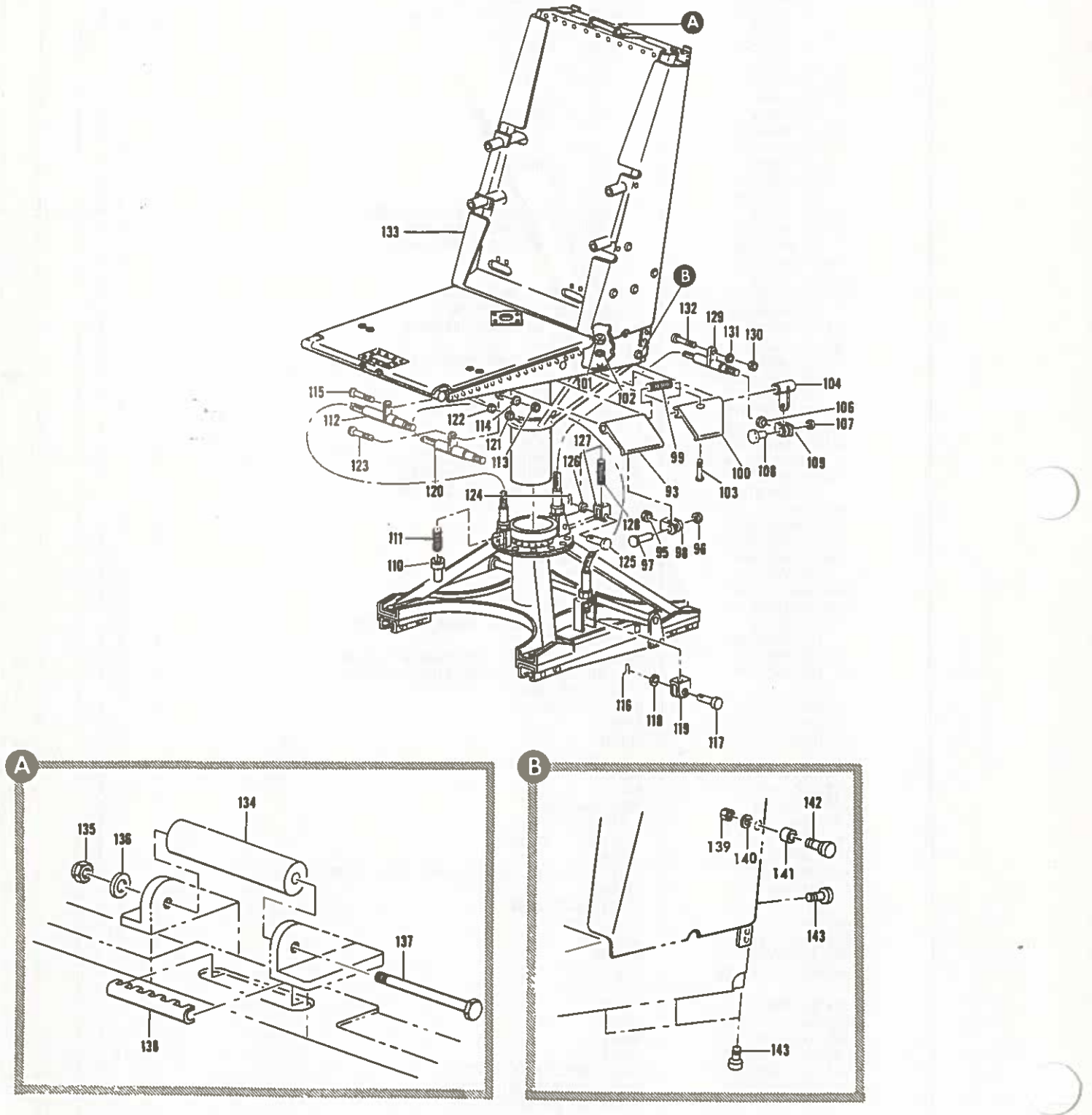

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1- -93	22-98549	. HANDLE, HORIZONTAL CONTROL MAKE FROM 22-98547		1		1
	22-98547	HANDLE		1		REF
		ATTACHING PARTS				
-94	AN380-2-1	. PIN, COTTER		1		1
-95	AN315-3R	. NUT		1		1
-96	AN960-4	. WASHER		1		1
-97	MS20392-1-19	. PIN		1		1
		----X----				
-98	22-98595	. CLEVIS		1		1
-99	22-98378	. SPRING		1		1
-100	22-98550	. HANDLE, VERTICAL CONTROL MAKE FROM 22-98547		1		1
	22-98547	HANDLE		1		REF
		ATTACHING PARTS				
-101	NAS679A3	. NUT		1		1
-102	AN960-10L	. WASHER		1		1
-103	NAS623-3-13	. SCREW		1		1
		----X----				
-104	22-98354	. BELL CRANK ASSEMBLY, VERTICAL CONTROL WELDED		1		1
		ATTACHING PARTS				
-105	AN380-2-1	. PIN, COTTER		1		1
-106	AN315-3R	. NUT		1		1
-107	AN960-4	. WASHER		1		1
-108	MS20392-1-13	. PIN		1		1
		----X----				
-109	22-98595	. CLEVIS		1		1
-110	22-98368	. PIN, INDEX		1		1
-111	22-98380	. SPRING, INDEX PIN		1		1
-112	40433-6	. CABLE, SWIVEL CONTROL -V80523-		1		1
		ATTACHING PARTS				
-113	NAS679A4	. NUT		1		1
-114	AN960-416	. WASHER		1		1
-115	AN4-4A	. BOLT		1		1
		----X----				
-116	AN380-2-1	. PIN, COTTER		1		1
-117	MS20392-1-13	. PIN		1		1
-118	AN960-4	. WASHER		1		1
-119	22-98595	. CLEVIS		1		1
-120	40433-7	. CABLE, HORIZONTAL CONTROL -V80523-		1		1
		ATTACHING PARTS				
-121	NAS679A4	. NUT		1		1
-122	AN960-416	. WASHER		1		1
-123	AN4-4A	. BOLT		1		1
		----X----				
-124	AN380-2-1	. PIN, COTTER		1		1
-125	MS20392-1-13	. PIN		1		1
-126	AN960-4	. WASHER		1		1
-127	22-98595	. CLEVIS		1		1
-128	630B10022	. SPRING, RETAINER -V70203-		1		1
-129	40433-6	. CABLE, VERTICAL CONTROL -V80523-		1		1
		ATTACHING PARTS				
-130	NAS679A4	. NUT		1		1
-131	AN960-416	. WASHER		1		1
-132	AN4-4A	. BOLT		1		1
		----X----				
-133	22-98517-1	. STRUCTURE ASSEMBLY, SEAT UPPER		1		1
-134	22-98530-55	. . ROLLER, SEAT		1		1
		ATTACHING PARTS				
-135	NAS679A3	. . NUT		1		1
-136	AN960-10	. . WASHER		1		1
-137	AN3-77A	. . BOLT		1		1
		----X----				
-138	22-98517-45	. . GROMMET		1		1
-139	NAS679A08	. . NUT		1		2
-140	AN960-8	. . WASHER		1		2
-141	22-98513-43	. . SPACER, SEAT		1		2
-142	AN227-10M10	. . STUD		1		2
-143	AN227-8	. . STUD		1		25

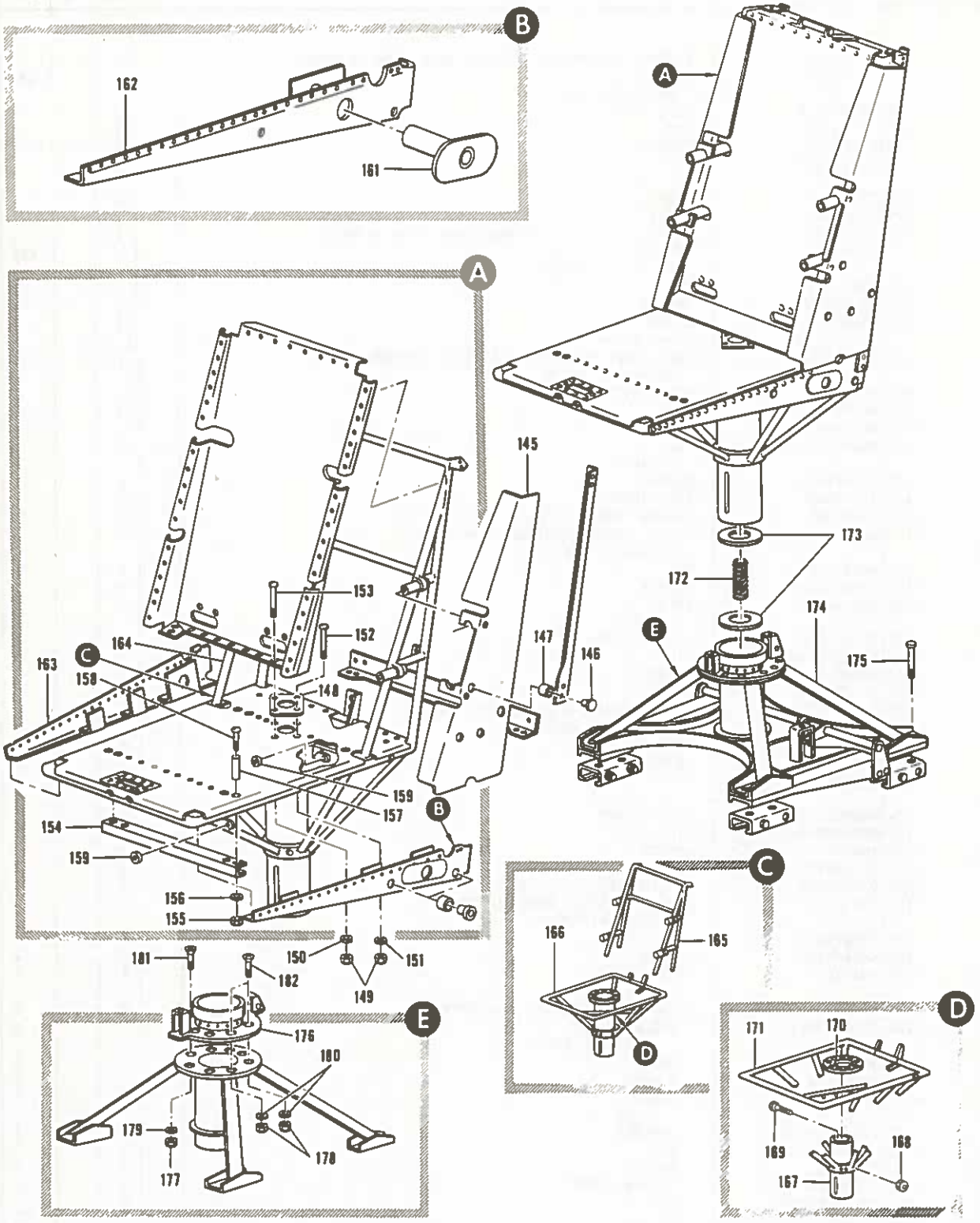

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1- -144	MS20600B4-2	. . RIVET, CONVAIR 97-63000-002		1		175
-145	22-98567-1	. . SHROUD ASSEMBLY, SEAT LH RIVETED		1		1
	22-98567-2	. . SHROUD ASSEMBLY, SEAT RH RIVETED		1		1
-146	AN227-8	. . STUD		1		4
-147	22-98513-43	. . SPACER, SEAT		1		4
-148	22-98517-19	. . PLATE		1		1
		ATTACHING PARTS				
-149	AN365-1032	. . NUT		1		4
-150	AN960-10	. . WASHER		1		2
-151	AN960-10L	. . WASHER		1		2
-152	NAS623-3-3	. . SCREW		1		2
-153	NAS623-3-4	. . SCREW		1		2
		----X----				
-154	22-98513-13	. . CHANNEL, REINFORCEMENT		1		1
		ATTACHING PARTS				
-155	NAS679A08	. . NUT		1		4
-156	AN960-8	. . WASHER		1		4
-157	NAS43-3-35	. . SPACER		1		4
-158	NAS623-2-13	. . SCREW		1		4
		----X----				
-159	NAS77A8-09P	. . BUSHING		1		2
-160	22-98517-9	. . TUBE AND FAIRING ASSEMBLY, SEAT UPPER LH		1		1
-161	22-98517-11	. . . TUBE ASSEMBLY, WELDED		1		1
-162	22-98513-9	. . . FAIRING ASSEMBLY, LH WELDED		1		1
-163	22-98513-10	. . FAIRING ASSEMBLY, RH WELDED		1		1
-164	22-98517-7	. . STRUCTURE ASSEMBLY, SEAT UPPER		1		1
-165	22-98510-3	. . . STRUCTURE ASSEMBLY, SEAT BACK WELDED		1		1
-166	22-98518-3	. . . STRUCTURE ASSEMBLY, SEAT BUCKET		1		1
-167	22-98518-49	. . . . TUBE ASSEMBLY, WELDED		1		1
		ATTACHING PARTS				
-168	NAS679A3	. . . . NUT		1		6
-169	NAS1103-8	. . . . BOLT		1		6
		----X----				
-170	22-98578	. . . . RETAINER, SPRING SEAT		1		1
-171	22-98518-7	. . . . FRAME ASSEMBLY, WELDED		1		1
-172	22-98375	. SPRING		1		1
-173	22-98596	. DISC, SPRING		1		2
-174	22-98509-1	. STRUCTURE ASSEMBLY, SEAT BASE		1		1
		ATTACHING PARTS				
-175	NAS1104-5	. BOLT		1		8
		----X----				
-176	22-98519-1	. . CONTROL ASSEMBLY, VERTICAL AND SWIVEL		1		1
		SEAT BASE				
		ATTACHING PARTS				
-177	NAS679A4	. . NUT		1		6
-178	NAS679A6	. . NUT		1		2
-179	AN960-416L	. . WASHER		1		6
-180	AN960-616L	. . WASHER		1		2
-181	NAS1204-6	. . BOLT		1		6
-182	NAS1206-8	. . BOLT		1		2
		----X----				

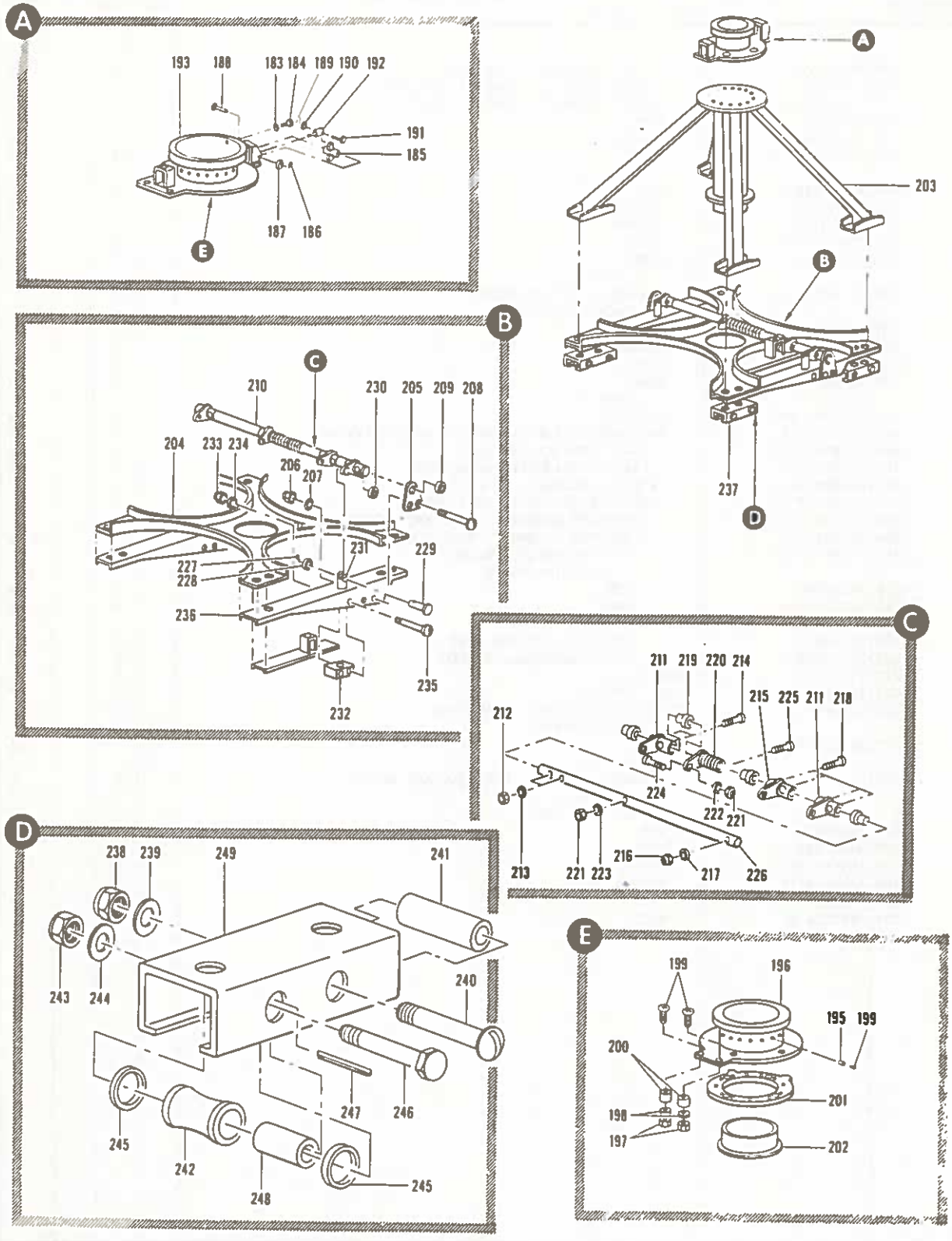

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1- -183	AN316-6R	. . . NUT		1		1
-184	22-98519-25	. . . SET SCREW		1		1
	22-98519-19	. . . SCREW, SET ALT-INTCHG WITH 22-98519-25		1		REF
-185	22-98519-47	. . . BELL CRANK ASSEMBLY, WELDED		1		1
		ATTACHING PARTS				
-186	AN380-2-1	. . . PIN, COTTER		1		1
-187	AN960-10L	. . . WASHER		1		1
-188	MS20392-2-43	. . . PIN		1		1
-189	AN380-2-1	. . . PIN, COTTER		1		1
-190	AN960-4	. . . WASHER		1		1
-191	MS20392-1-12	. . . PIN		1		1
		----X----				
-192	22-98519-29	. . . PIN		1		1
-193	22-98519-7	. . . SWIVEL ASSEMBLY		1		1
-194	HS2R7C6-3	. . . . RIVET, -V73197-		1		18
-195	NAS179-6	. . . . COLLAR, -V73197-		1		18
-196	22-98519-9	. . . . BRACKET ASSEMBLY, WELDED		1		1
		ATTACHING PARTS				
-197	NAS679A3	. . . . NUT		1		2
-198	AN960-10L	. . . . WASHER		1		2
-199	NAS623-3-6	. . . . SCREW		1		2
		----X----				
-200	22-98519-27	. . . . BUSHING		1		2
-201	22-98519-23	. . . . RING		1		1
-202	22-98519-21	. . . . SLEEVE		1		1
-203	22-98508	. . SUPPORT ASSEMBLY, SEAT BASE WELDED		1		2
-204	22-98529	. . SPIDER, SEAT BASE		1		1
-205	22-98509-11	. . SUPPORT, SEAT BASE		1		2
		ATTACHING PARTS				
-206	NAS679A3	. . NUT		1		2
-207	AN960-10	. . WASHER		1		2
-208	NAS623-3-22	. . SCREW		1		2
		----X----				
-209	NAS77A8-09P	. . BUSHING		1		2
-210	22-98583	. . CONTROL ASSEMBLY, SEAT HORIZONTAL		1		1
-211	22-98583-7	. . . BELL CRANK ASSEMBLY, BRAZED		1		2
		ATTACHING PARTS				
-212	NAS679A08	. . . NUT		1		4
-213	AN960-8L	. . . WASHER		1		4
-214	NAS623-2-10	. . . SCREW		1		4
		----X----				
-215	22-98583-9	. . . BELL CRANK ASSEMBLY, BRAZED		1		1
		ATTACHING PARTS				
-216	NAS679A08	. . . NUT		1		2
-217	AN960-8L	. . . WASHER		1		2
-218	NAS623-2-10	. . . SCREW		1		2
		----X----				
-219	NAS77A8-12P	. . . BUSHING		1		2
-220	22-98371-2	. . . SPRING, LOAD		1		1
		ATTACHING PARTS				
-221	NAS679A3	. . . NUT		1		2
-222	AN960-10	. . . WASHER		1		1
-223	AN960-10L	. . . WASHER		1		1
-224	NAS623-3-3	. . . SCREW		1		1
-225	NAS623-3-9	. . . SCREW		1		1
		----X----				
-226	22-98583-19	. . . TUBE, TORQUE		1		1
-227	AN380-2-1	. . PIN, COTTER		1		2
-228	AN960-4	. . WASHER		1		2
-229	MS20392-1-13	. . PIN		1		2
-230	NAS77A4-72P	. . BUSHING		1		2
-231	22-98609-7	. . PIN, TRACK LOCK		1		2

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1- -232	22-98509-13	. . BLOCK, TRACK LOCK		1		2
		ATTACHING PARTS				
-233	NAS679A3	. . NUT		1		2
-234	AN960-10	. . WASHER		1		2
-235	NAS623-3-21	. . SCREW		1		2
		----X----				
-236	22-98509-19	. . SPREADER, LH		1		1
	22-98509-20	. . SPREADER, RH		1		1
-237	22-98592-3	. GRIPPER ASSEMBLY, BASE LH		1		2
	22-98592-4	. GRIPPER ASSEMBLY, BASE RH		1		2
-238	NAS679A4	. . NUT		1		1
-239	AN960-416L	. . WASHER		1		1
-240	NAS623-4-19	. . SCREW		1		1
-241	NAS75-4-104	. . BUSHING		1		1
-242	22-98560	. . ROLLER, BASE GRIPPER		1		1
		ATTACHING PARTS				
-243	NAS679A4	. . NUT		1		1
-244	AN960-416L	. . WASHER		1		1
-245	NAS43HT7-3	. . SPACER		1		2
-246	22-98362-7	. . BOLT		1		1
		----X----				
-247	AN280H202	. . KEY		1		1
-248	22-98592-9	. . BUSHING		1		1
-249	22-98592-7	. . GRIPPER, LH		1		1
	22-98592-8	. . GRIPPER, RH		1		1

OBSERVER'S SEAT INSTALLATION
(Convair Part No. 30-91512-1)

ATA NO. 25-1-3

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Model 30-5 Jan. 19/62

List of Effective Pages

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Chapter 25-1-3

OBSERVER'S SEAT
(Convair Part No. 30-91512-1)

1. Description and Operation

A. Physical Description.

(1) The observer's seat, part number 30-91512-1, is manufactured by Aircraft Mechanics, Inc., Colorado Springs, Colorado. This chapter contains complete step by step overhaul procedures, prepared by the manufacturer to standards established by Air Transport Association Specification Number 100 for inclusion in the CONVAIR Overhaul Manual.

(2) The seat consists of six major components, the headrest assembly, seat pan assembly, armrest assembly, footrest assembly and two structure installations. The seat is attached directly to the structure of the flight compartment.

(3) The seat provides a foam padded detachable seat cushion. All other cushions are cemented to structure. Seat belt and shoulder harness are furnished.

B. Leading Particulars.

Overall height, seat in extended position . . . . . 53 inches
Overall height, seat in folded position . . . . . 30 inches
Capacity, occupant . . . . . 200 inches

C. Operation.

To fold seat unlock pins, located on both right hand and left hand sides of seat, this will permit footrest to fold and lock in position by spring clip as seat bottom is raised to folded position. Lift armrest to raised position and secure seat and armrest with strap attached to left hand side of seat. To secure strap use pin through strap end, seat bottom clip and foot support leg on left hand side of seat.

To unfold seat unlock pin securing seat and armrest on left hand side of seat. Lower seat pan and footrest. Insert pin through seat pan and strut assembly locking in place. Pull foot pan assembly forward and down. Lower armrest to down position.

2. Disassembly

A. General.

(1) All foam except that in the seat cushion is cemented in place and is likely to be damaged beyond use in removal. Handle cemented foam pieces with care to avoid pulling or stressing foam. Refer to paragraph 5.B. for procedure to remove foam.

B. Disassembly of Observer's Seat Installation. (See IPC Figure 1.)

(1) Remove shoulder harness (79). Unhook strap (30).

(2) Unsnap seat pan upholstery (22) and seat back upholstery (70).

(3) Remove footrest assembly (111) by removing two screws (6), two spacers (7), four washers (8) and two nuts (9) and two screws (18), two bushings (19), two washers (20), and two nuts (21).

(4) Pull two pin assemblies (2) and move two strut assemblies (5) aft to line of access holes. Remove four lock rings (3) and two leg guide pins (4). This releases the strut assemblies (5).

C. Seat Pan Assembly.

(1) Remove seat pan assembly by removing screw (10), bushing (11), washer (12), nut (13), screw (14), bushing (15), washer (16) and nut (17).

NOTE: The seat pan cushion (23) and seat pan filler (24) are cemented to seat pan and should be removed only if necessary for repair or replacement.

(2) Remove crotch strap fitting (25) by removing two screws (26). Remove four bushings (27) and four bushings (28) from seat pan (29).

D. Armrest Assemblies.

(1) Remove two armrest assemblies by removing two screws (31), two bushings (32), two washers (33), two nuts (34), two screws (35), two bushings (36), two washers (37) and two nuts (38). Remove armrest upholstery (39).

NOTE: The armrest cushion (40) is cemented to armrest structure and should be removed only if necessary for repair or replacement.

(2) Remove armrest link rod (41) by removing bolt (42), spacer (43), two washers (44) and nut (45). Remove screw (46). Remove eye-bolt (47), washer (48) and insert (49) from armrest link tube (50). Armrest (51) remains.

(3) Remove screw (52), spacer (53), two washers (54) and nut (55) from fitting (56). Remove fitting by removing two bolts (57) and two nuts (58). Remove two upper armrest linkage fittings (59) by removing four screws (60) four washers (61) and four nuts (62).

E. Headrest Assembly.

(1) Remove headrest pan assembly (67) by removing three screws (63). Unsnap headrest upholstery (64).

NOTE: The headrest cushion (65) and headrest filler (66) are cemented to the headrest pan and should be removed only if necessary for repair or replacement.

F. Seat Structure Installation.

(1) Remove four screws (68) and four nuts (69) through fairing (73).

NOTE: The backrest cushion (71) and backrest filler (72) are cemented to the backrest and should be removed only if necessary for repair or replacement.

G. Seat Structure Installation.

(1) Remove strap (74) by removing screw (75), spacer (76), washer (77) and nut (78).

(2) Remove left and right hand baffles (90) by removing ten screws (88) and ten nuts (89). Remove plate (95), six nuts (94) and two nuts (92).

(3) Detach backrest assembly (107) by removing two screws (96), two washers (97),and two nuts (98). Remove backrest angle (99) by removing two screws (100), two washers (101) and two nuts (102). Remove backrest angle (103) by removing eight screws (104), eight washers (105) and eight nuts (106).

(4) Remove bushing (108) and bushing (109) from structures (110).

(5) Remove two pins (80), two nuts (81) and two washers (82) and two bushings (83), two bolts (84), two bushings (85), two washers (86) and two nuts (87). These are used in installing the structures (110).

H. Observer's Seat Footrest Assembly. (See IPC Figure 2.)

(1) Remove four cotter pins (2), four clevis pins (3) and four washers (4). Removing four terminals (5) and four nuts (6) will leave two footrest rods(7).

(2) Remove footrest support link assemblies (8) by removing two rings (9), two footrest pins (10), two spacers (11), two washers (12), two washers (13) and two bolts (14), four washers (15), four washers (16) and two nuts (17). Remove footrest fitting assemblies by removing four screws (18), four washers (19), four washers (20) and four nuts (21). Remove bushing (22) from footrest fitting (23).

(3) Remove footrest leg assemblies by removing two bolts (24), two bushings (25), four washers (26), four washers (27) and two nuts (28). Remove bushing (29) and bushing (30) from footrest leg (31). Foot pan assembly (32) remains.

NOTE: The footrest cover (1) is riveted on and should be removed only if necessary to repair or replace.

3. Cleaning

A. General.

(1) Use soap and water to clean covers while installed over foam, as cleaning solvents are injurious to foam rubber.

(2) Use any standard commercial dry cleaning procedure on a cover which has been removed.

(3) Use soap and water to clean foam rubber, boltron fairings and naugahide covers.

(4) Clean metal parts contaiminated with oil or grease with cleaning solvent specified in paragraph 6.H.(9) or equivalent.

WARNING: USE CLEANING SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND AVOID CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

B. Types of Cleaning Agents.

(1) No single type of cleaning agent is completely effective in the removal of all soiling; each product has its limitations. The instructions given on the product containers should be carefully followed to insure best results.

(2) Concentration detergent preparations, commonly called upholstery shampoo, are effective in removing dry or waterborne soil. Recommended detergent preparations are specified in paragraph 6.H.(1), (2), (3), and (4).

(3) Solvent type cleaning agents are effective in removal of oil-type soil or grease spots. Recommend solvent type cleaning agents are specified in paragraph 6.H.(5), (6), and (7). Solvent impregnated powder, specified in paragraph 6.H. (8), may be used instead of solvent cleaning agents.

C. Cleaning Procedure.

(1) Vacuum upholstery thoroughly, or brush with a medium stiff bristle upholstery or clothing brush. Do not pound or beat.

(2) Test material to be cleaned by first applying cleaning agent to a small obscure area of material.

(3) Use solvent type cleaning agent or solvent impregnated powder to remove oil-type soil or grease stains. Use cleaning material sparingly, without saturating fabric, to avoid damage to foam.

Apply cleaning agent with a clean soft cloth, and avoid spreading any stains by working from the outer edges toward the center.

WARNING: WORK IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS. KEEP AWAY FROM OPEN FLAMES.

NOTE: Solvents should be evaporated rapidly from the fabric surface by directing an air stream from a vacuum cleaner, or by fanning, toward material to avoid formation of rings.

4. Inspection

A. General.

Where doubt exists concerning serviceability of standard AN, NAS, and MS parts, the part should be renewed.

B. Visual Inspection.

Under strong light, preferably under magnification, visually inspect all parts, as applicable, for scored or stripped threads, cracks, nicks, scratches, dents, corrosion and excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of parts.

C. Dye Penetrant Inspection.

Refer to Military Specification MIL-I-6866.

D. Magnetic Particle Inspection.

Refer to Military Specification MIL-I-6868.

E. Component Inspection.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
1-2	Pin assembly	Visual - scores, cracks, operation of ball lock.
1-4	Guide pin	Visual - scores, cracks
1-5	Strut assembly	Visual - scores, cracks, elongated holes.
1-22, 1-39 1-64, 1-70	Upholstery	Visual - cleanliness, tears, wear, holes.
1-23, 1-40, 1-65, 1-71	Cushion	Visual - cleanliness, tears, deterioration.
1-24, 1-66, 1-72	Filler	Visual - cracks, tears, separation.
1-25	Crotch strap fitting	Visual - cracks, elongated holes.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
1-29	Seat pan assembly	Visual - cracks, distortion, damage.
1-41	Link rod	Visual - cracks, chips, magnetic particle inspection per paragraph 4.D.
1-50	Armrest link tube	Visual - cracks, chips, magnetic particle inspection per paragraph 4.D.
1-51	Armrest	Visual - sheared or cracked rivets.
1-56	Fitting,	Visual - cracks, elongated holes, dye penetrant inspection per paragraph 4.C.
1-59	Fitting,	Visual - cracks, elongated holes
1-67	Headrest pan	Visual - cracks, damage, security of nut plates.
1-73	Fairing	Visual - cracks, damage, elongated holes.
1-74	Strap	Visual - wear, damage, cleanliness.
1-90	Baffle	Visual - cracks, damage, security of studs, elongated holes.
1-96	Plate	Visual - cracks, damage, distortion, security of studs, elongated holes.
1-99	Angle	Visual - cracks, damage, security of studs.
1-103	Backrest assembly	Visual - cracks, damage, security of studs.
1-107	Backrest assembly	Visual - cracks, separation of lamination, wood splitting.
1-110	Structure	Visual - damage, sheared or cracked rivets, dents, misalignment, elongated holes.
2-1	Footrest cover	Visual - cleanliness, tears, wear, holes.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
2-7	Footrest rod	Visual - damage, wear, stripped threads.
2-8	Link assembly	Visual - damage, sheared or cracked rivet, check spring clip for cracks or breaks, magnetic particle inspection per paragraph 4.D.
2-10	Footrest pin	Visual - scores, cracks, wear.
2-23	Footrest fitting	Visual - cracks, elongated holes.
2-31	Footrest leg	Visual - cracks, elongated holes, dye penetrant inspection per paragraph 4.C.
2-32	Foot pan assembly	Visual - cracks, damage, elongated holes, separation of lamination, check non-slip material on top surface.

5. Repair

A. General.

(1) Minor nicks and scratches may be removed from aluminum alloy parts by polishing with oxide abrasive cloth specified in paragraph 6.H.(13) or equivalent. Clean all parts thoroughly after polishing.

(2) Minor nicks and scratches may be removed from non-critical steel parts by polishing with crocus cloth specified in paragraph 6.H.(14) or equivalent. Clean all parts thoroughly after polishing.

(3) Use standard shop practice for minor repair of sheet metal and/or riveted pieces.

(4) Components not satisfying inspection requirements must be repaired before seat is returned to service or storage. Repairs are listed in the following paragraphs. Components which require inspection and are not listed in these paragraphs should be renewed if damaged or worn.

B. Cemented Foam.

(1) All foam pads except removable seat pad are cemented to the metal structure. The cemented joint normally is stronger than the foam itself and usually will be damaged beyond use during removal operations. Foam damage during removal should not be reinstalled. Short sections of the cemented joint can be opened and re-cemented.

(2) To remove foam for renewal, use a sharp thin knife to cut the foam close to the cemented joint while pulling foam away from the structure. Most of the foam should come off, leaving a thin layer of foam and cement on the metal. If a relatively even surface is obtained, new foam may be installed over this thin layer. If the layer is thick or uneven, strip down to bare metal before installing new foam. Use commercial grade acetone as solvent to soak layer before using a dull metal blade to scrap layer from metal.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

CAUTION: ACETONE CAUSES FOAM BREAKDOWN. DO NOT USE ACETONE IN MAKING MINOR REPAIRS. DO NOT RE-USE FOAM SOAKED BY ACETONE.

(3) If foam is torn or loose, but is otherwise usable, cement the tear or the loose joint. Apply cement specified in paragraph 6.H.(10), or equivalent, to both sides of joint and allow to air dry until tacky. Press joint together and hold briefly.

NOTE: There is some local stiffening of foam at cemented joints. Avoid heavy or extensive cementing on seat foam surfaces or edges.

6. Assembly

A. Observer's Seat Footrest Assembly.(See IPC Figure 2.)

(1) Insert bushing (29) and bushing (30) into footrest leg (31). Attach footrest pan assembly (32) with two bolts (24), two bushings (25), four washers (26), four washers (27) and two nuts (28).

(2) Insert bushing (22) into footrest fitting (23). Attach footrest fittings (23) to footpan assembly (32) with four screws (18), four washers (19), four washers (20) and four nuts (21).

(3) Connect footrest support link assemblies (8) by attaching with two rings (9), two footrest pin (10), two spacers (11), two washers (12), two washers (13) and two bolts (14), four washers (15), four washers (16) and two nuts (17).

(4) Add terminals (5) and four nuts (6) to two footrest rods (7). Attach two footrest rods (7) to footrest legs (31) with four pins (3), four washers (4) and four pins (2).

(5) Attach footrest cover (1) if removed for repair or replacement.

B. Seat Structure Installation. (See IPC Figure 1.)

(1) Insert bushing (108) and bushing (109) into structures (110). Install structures (110) with two pins (80), two nuts (81) and two washers (82), two bushings (83), two bolts (84), two bushings (85), two washers (86) and two nuts (87).

(2) Attach backrest angle (103) with eight screws (104), eight washers (105) and eight nuts (106). Attach backrest angle (99) with two screws (100), two washers (101) and two nuts (102). Install backrest assembly (107) with two screws (96), two washers (97) and two nuts (98).

(3) Attach plate (95) with six screws (91), six washers (93), six nuts (94) and two screws (92). Attach baffles (90) by ten screws (88) and ten nuts (89).

(4) Install strap (74) with screw (75), spacer (76), washer (77) and nut (78).

C. Seat Structure Installation.

(1) Attach backrest filler (72) and backrest cushion (71) if removed for repair or replacement.

(2) Install fairings (73) with four screws (68) and four nuts (69).

D. Headrest Assembly.

(1) Attach headrest filler (66) and headrest cushion (65) if removed for repair or replacement.

(2) Snap on headrest upholstery (64). Attach headrest pan assembly (67) with three screws (63).

E. Armrest Assemblies.

(1) Attach two upper armrest linkage fittings (59) with four screws (60), four washers (61) and four nuts (62). Attach fitting (56) with two bolts (57) and two nuts (58). Add to fitting (56) screw (52), spacer (53), two washers (54) and nut (55).

(2) Add insert (49), washer (48) and eyebolt (47) to armrest link tube (50). Add screw (46) to armrest link rod (41) and insert armrest link rod (41) into armrest link tube (50). Attach armrest link rod (41) to armrest (51) with bolt (42), spacer (43), two washers (44) and nut (45).

(3) Attach armrest cushion (40) and upholstery (39) if removed for repair or replacement.

(4) Attach armrest assemblies with two screws (31), two bushings (32), two washers (33), two nuts (34) and two screws (35), two bushings (36), two washers (37), and two nuts (38).

F. Seat Pan Assembly.

(1) Insert four bushings (28) and four bushings (27) into seat pan (29). Attach crotch strap fitting (25) with two screws (26).

(2) Attach seat pan filler (24) and seat pan cushion (23) if removed for repair or replacement.

(3) Attach seat pan (29) with screw (10), bushing (11), washer (12), nut (13), screw (14),bushing (15), washer (16) and nut (17).

G. Seat Installation.

(1) Insert two strut assemblies (5) and install two leg guide pins (4) with four lock rings (3). Move strut forward and insert two pin assemblies (2) locking strut.

(2) Attach footrest assembly (111) with two screws (6), two spacers (7), four washers (8) and two nuts (9), two screws (18), two bushings (19), two washers (20) and two nuts (21).

(3) Snap on seat back upholstery (70) and seat pan upholstery (22).

(4) Attach strap (30) and install shoulder harness (79).

H. Materials.

Use materials recommended or equivalents.

MATERIAL	IDENTIFICATION	SOURCE
(1) Upholstery cleaner	Foam Cleaner	E.I. Du Pont de Nemours & Co. (Inc.) Wilmington, Delaware.
(2) Upholstery cleaner	Glamorene	Glamorene Incorp. 270 Park Ave., New York, New York.
(3) Upholstery cleaner	Mystic Foam	Mystic Foam Corp. Cleveland, Ohio.
(4) Upholstery cleaner	Duo-Dellay	Duo-Dellay Products Co., 4201 Puleshi Highway, Baltimore, Maryland.
(5) Upholstery cleaner	Du Pont Dry Clean	E.I. Du Pont de Nemours & Co. (Inc.) Wilmington, Delaware.
(6) Upholstery cleaner	Carbone Instant Foam Lather	Carbone Corporation, 30-50 Greenpoint Ave., Long Island City 1, New York.
(7) Upholstery cleaner	Carbone Cleaning Fluid	Carbone Corporation, 30-50 Greenpoint Ave., Long Island City 1, New York.
(8) Upholstery cleaner	Powder-ene	Von Schroder Manufacturing Co., Racine, Wisconsin.
(9) Cleaning solvent	Federal Specification P-S-661	Optional
(10) Cement	EC-1300	3-M Corporation, St. Paul, Minnesota.
(11) Cement	Rubber to Metal T-161 Sta-Bond	American Latex Products Corp., 3341 West El Segundo Blvd., Hawthorne, California.

MATERIAL	IDENTIFICATION	SOURCE
(12) Cement	Rubber to Rubber H-125 Sta-Bond	American Latex Products Corp., 3341 West El Segundo Blvd., Hawthorne, California.
(13) Abrasive cloth	No.600 to 800 grade, Federal Specification P-C-451	Optional
(14) Crocus cloth	Federal Specification P-C-458	Optional
(15) Wrapping paper	Federal Specification UU-P-271	Optional
(16) Tape	Federal Specification JAN-P-127	Optional

7. Fits and Clearances

This section is not applicable to this assembly.

8. Testing

A. Safety Belt.

Test to current F.A.A. requirements.

B. Seat Operation.

(1) For armrest folding qualities, check for binding and adjustments.

(2) Raise seat and check for binding and interference of upholstery snaps.

(3) Pull pin assembly. Fold footrest and insert pin in strap end, seat bottom clip and foot support leg in order to check for complete insertion and locking.

(4) Fold foot pan assembly by raising to locking clip. Check clip for complete locking.

(5) To lower seat remove pin from inserted position and lower seat allowing footrest to swing forward to vertical position. Insert pin through seat pan side frame at bushing (IPC Figure 1, 28) and strut assembly (5). Check pin assembly (2) for for complete insertion and locking.

(6) Lower foot pan (IPC Figure 2, 21) by pulling forward and down.

(7) Lower armrests and check for alignment.

9. Trouble Shooting

OBSERVER'S SEAT INSTALLATION - TROUBLE SHOOTING

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
A. ARMREST DOES NOT MOVE OR IT BINDS.	
(1) Armrest link tube (IPC Figure 1, 50) will not slide over armrest link rod (41).	Remove armrest link tube and check for foreign particles and burrs. Also, armrest link tube or armrest link rod may be out of round. Remove burrs or foreign particles. If armrest link rod and armrest link tube are out of round replace with new parts.
(2) Bushing at armrest pivot point (32) may be binding in fitting (59).	Remove screw and check bushing for adequate length. Check bushing for out of round and galling. If out of round, ream barrel or replace. If galled polish bushing. Replace if necessary.
B. FOOTREST BECOMES LOOSE.	
(1) Pin assembly (2) failed to lock.	Remove pin assembly and check actuation. If pin does not release balls when trip lever has been activated, pin assembly must be replaced.
(2) Pin assembly not long enough to lock all components as designed.	Push pin assembly into receptical as far as possible with lever activated. Then release lever. If not locked, check seat pan assembly (IPC Figure 1, 29) for distortion.
C. SEAT PAN ASSEMBLY WILL NOT FOLD UP.	
(1) Lap belt assembly prevents seat from folding.	Unfasten lap belt buckle.
(2) Upholstery snaps strike armrest assembly.	Check snap for being unsnapped. Resnap all loose snaps or realign armrest.

10. Storage Instructions

A. The seat assembly is essentially corrosion resistant and no special preservation is required.

B. Wrap seat in waterproof wrapping paper specified in paragraph 6.H.(15), or a plastic cover. Use tape specified in paragraph 6.H.(16), or equivalent, to secure wrapping paper, or cover. Stamp seat assembly part number and date of overhaul on a tag, or in a convenient location on seat wrapper.

C. Store seat in a cool dry area, below 68 degrees F., away from sunlight and heat source.

11. Special Tools, Fixtures and Equipment

No special tools, fixtures or equipment are needed for overhaul of the seat.

OBSERVER SEAT INSTALLATION

(Convair Part No. 30-91512-1)

Applicable To Model 30-5 Jan. 19/62

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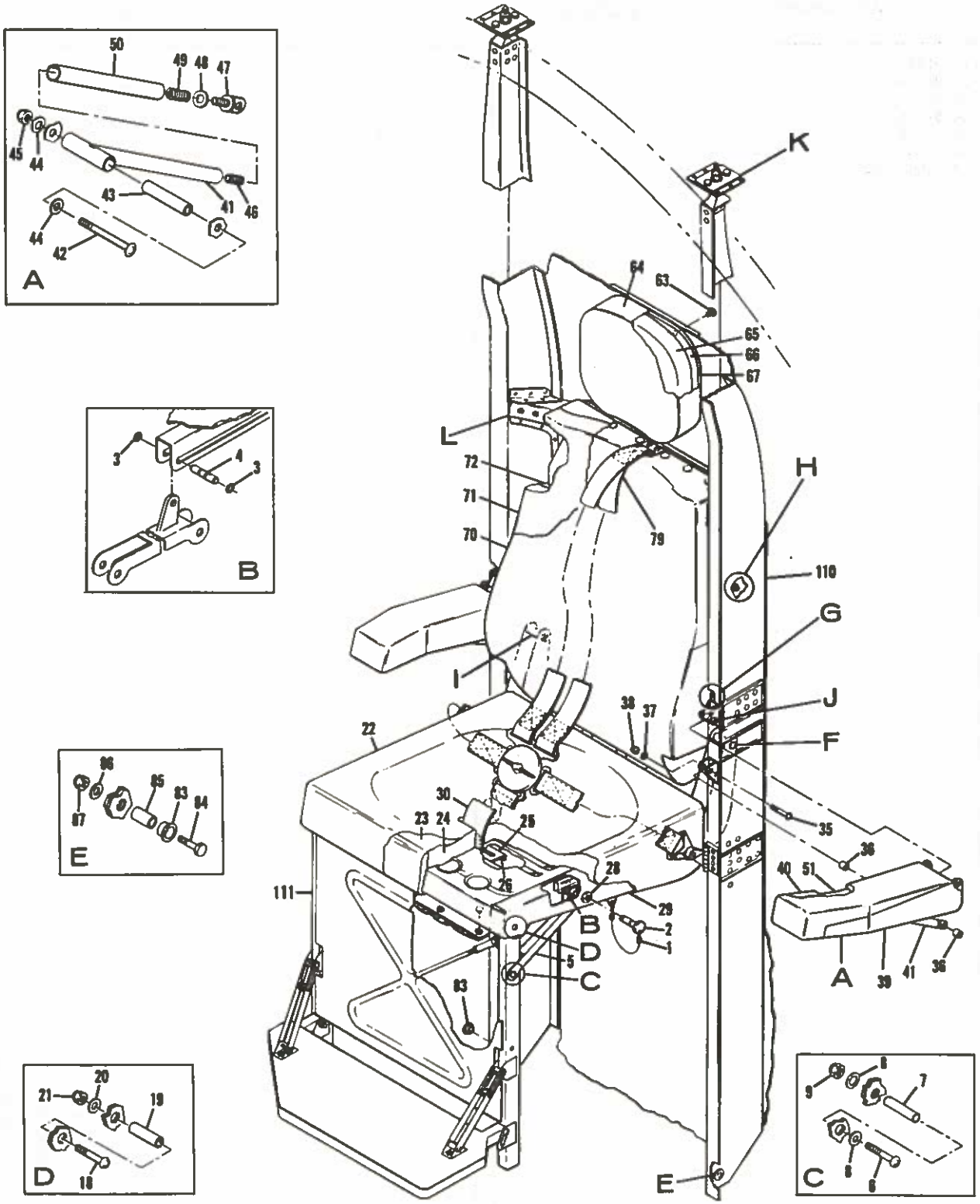

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-37	AN960-416L	. WASHER		1		2
-38	NAS679A4	. NUT		1		2
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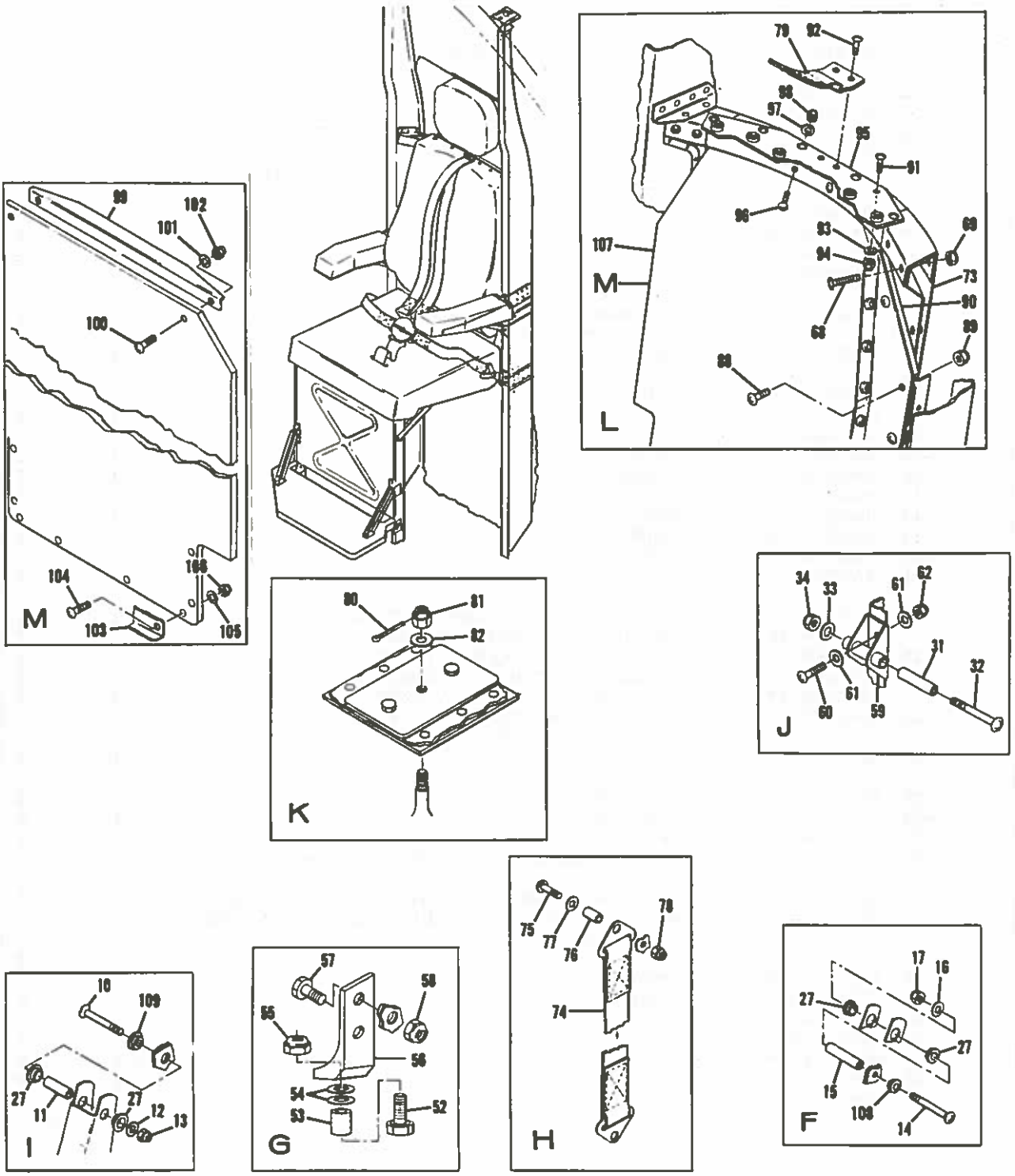
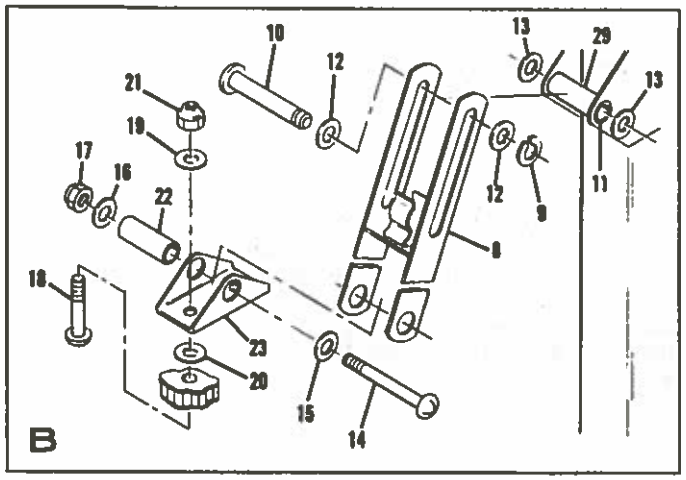
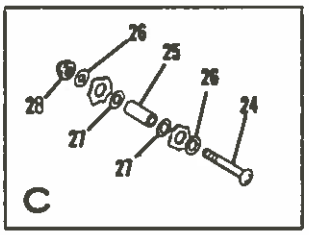

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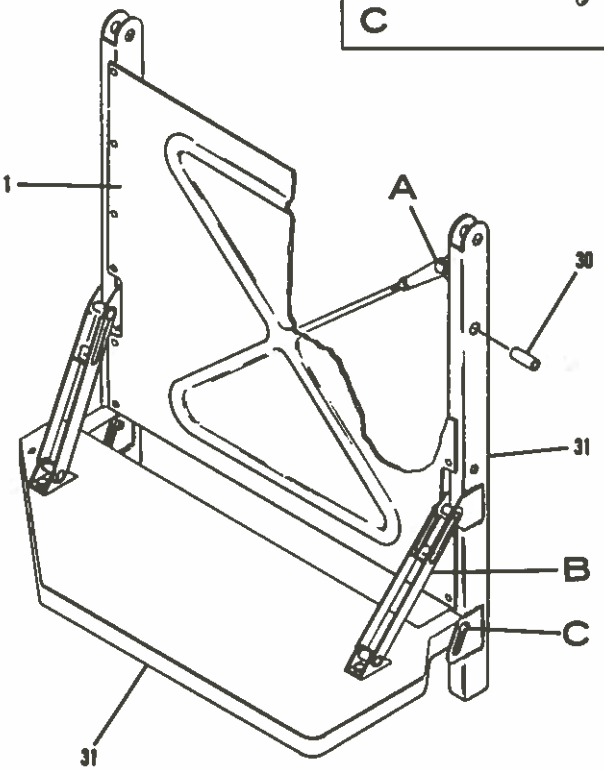
FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1- -39	30-91522-1	. . UPHOLSTERY, ARMREST LH -V70203P		1		1
	30-91522-2	. . UPHOLSTERY, ARMREST RH -V70203P		1		1
-40	30-91523-1	. . CUSHION, ARMREST LH -V70203P		1		1
	30-91523-2	. . CUSHION, ARMREST RH -V70203P		1		1
-41	30-91528-1	. . ROD, ARMREST LINK -V70203P		1		1
		ATTACHING PARTS				
-42	NAS623-3-36	. . BOLT		1		1
-43	NAS43DD3-140	. . SPACER		1		1
-44	AN960PD10L	. . WASHER		1		2
-45	NAS679A3	. . NUT		1		1
		- - - - X - - - -				
-46	NAS1081-4-16	. . SCREW		1		1
	30-91529-1	. . TUBE ASSEMBLY, ARMREST LINK -V70203P		1		1
-47	AN43BC4A	. . . EYEBOLT		1		1
-48	AN960C416	. . . WASHER		1		1
-49	NAS1222-4E	. . . INSERT		1		1
-50	30-91529-7	. . . TUBE, ARMREST LINK -V70203P		1		1
-51	30-91530-1	. . ARMREST, OBSERVER SEAT LH -V70203P		1		1
	30-91530-8	. . ARMREST, OBSERVER SEAT RH -V70203P		1		1
-52	NAS428-4-10	. SCREW		1		1
-53	NAS43HT4-24	. SPACER		1		1
-54	AN960-416	. WASHER		1		2
-55	NAS1291-4	. NUT		1		1
-56	30-91565-7	. FITTING, OBSERVER SEAT -V70203P		1		1
		ATTACHING PARTS				
-57	NAS1104-3	. BOLT		1		2
-58	NAS1291-4	. NUT		1		2
		- - - - X - - - -				
-59	30-91535-1	. FITTING, ARMREST LINKAGE UPPER -V70203P		1		2
		ATTACHING PARTS				
-60	NAS221-6	. SCREW		1		2
	NAS623-3-3	. SCREW		1		2
-61	AN960D10L	. WASHER		1		4
-62	NAS679A3	. NUT		1		2
	NAS1291-3	. NUT		1		2
		- - - - X - - - -				
	30-91540-1	. HEADREST ASSEMBLY, OBSERVER SEAT -V70203P		1		1
		ATTACHING PARTS				
-63	NAS221-5	. SCREW		1		3
		- - - - X - - - -				
-64	30-91541-1	. . UPHOLSTERY, HEADREST -V70203P		1		1
-65	30-91539-7	. . CUSHION, HEADREST -V70203P		1		1
-66	30-91538-7	. . FILLER, HEADREST -V70203P		1		1
-67	30-91518-1	. . PAN, HEADREST -V70203P		1		1
	30-91502-3	. STRUCTURE INSTALLATION, OBSERVER SEAT -V70203P		1		1
-68	AN530-10R8	. . SCREW		1		4
-69	NAS395-26	. . NUT		1		4
-70	30-91512-1	. . UPHOLSTERY, SEAT BACK -V70203P		1		1
	30-91502-79	. . STRUCTURE ASSEMBLY, OBSERVER SEAT -V70203P		1		1
-71	30-91515-1	. . . CUSHION, BACKREST -V70203P		1		1
-72	30-91514-7	. . . FILLER, BACKREST -V70203P		1		1
-73	30-91542-7	. . FAIRING, OBSERVER SEAT LH -V70203P		1		1
	30-91542-9	. . FAIRING, OBSERVER SEAT RH -V70203P		1		1

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1- -74	30-91564-1	. STRAP, OBSERVER SEAT -V70203P		1		1
		ATTACHING PARTS				
-75	NAS221-9	. SCREW		1		1
-76	NAS43HT3-16	. SPACER		1		1
-77	AN960-10	. WASHER		1		1
-78	NAS1291-3	. NUT		1		1
		- - - - X - - - -				
-79	1101297-04	. HARNESS, OBSERVER SEAT CONVAIR 94-58000-002 -V45402		1		1
	30-91502-1	. STRUCTURE INSTALLATION, OBSERVER SEAT -V70203P		1		1
-80	AN380-3-4	. . PIN		1		2
-81	AN310-6	. . NUT		1		2
-82	AN960-616	. . WASHER		1		2
-83	NAS538-6-09	. . BUSHING		1		2
		ATTACHING PARTS				
-84	NAS1104-3	. . BOLT		1		2
-85	NAS75-4-006	. . BUSHING		1		2
-86	AN960-416L	. . WASHER		1		2
-87	NAS679A4	. . NUT		1		2
		- - - - X - - - -				
	30-91502-51	. . BAFFLE ASSEMBLY, OBSERVER SEAT LH -V70203P		1		1
	30-91502-52	. . BAFFLE ASSEMBLY, OBSERVER SEAT RH -V70203P		1		1
		ATTACHING PARTS				
-88	NAS221-9	. . SCREW		1		10
-89	NAS679A3	. . NUT		1		10
		- - - - X - - - -				
-90	30-91502-29	. . . BAFFLE, OBSERVER SEAT LH -V70203P		1		1
	30-91502-30	. . . BAFFLE, OBSERVER SEAT RH -V70203P		1		1
	30-91502-77	. . PLATE ASSEMBLY, OBSERVER SEAT -V70203P		1		1
		ATTACHING PARTS				
-91	NAS221-6	. . SCREW		1		6
-92	NAS221-7	. . SCREW		1		2
-93	AN960D10L	. . WASHER		1		6
-94	NAS679A3	. . NUT		1		6
		- - - - X - - - -				
-95	30-91502-75	. . . PLATE, OBSERVER SEAT -V70203P		1		1
	30-91508-1	. . BACKREST ASSEMBLY, OBSERVER SEAT -V70203P		1		1
		ATTACHING PARTS				
-96	NAS221-13	. . SCREW		1		2
-97	AN960-416L	. . WASHER		1		2
-98	NAS679A3	. . NUT		1		2
		- - - - X - - - -				
-99	30-91508-9	. . . ANGLE, BACKREST -V70203P		1		1
		ATTACHING PARTS				
-100	NAS221-9	. . . SCREW		1		2
-101	99-51509-038	. . . WASHER, FLAT ALUMINUM ALLOY -V70203P		1		2
-102	NAS679A3	. . . NUT		1		2
		- - - - X - - - -				
-103	30-91508-19	. . . ANGLE, BACKREST -V70203P		1		1
		ATTACHING PARTS				
-104	NAS221-9	. . . SCREW		1		8
-105	99-51509-038	. . . WASHER, FLAT ALUMINUM ALLOY -V70203P		1		8
-106	NAS679A3	. . . NUT		1		8
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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSY
1- -107	30-91508-7	. . . BACKREST ASSEMBLY -V70203P		1		1
	30-91502-7	. . STRUCTURE ASSEMBLY, OBSERVER SEAT LH -V70203P		1		1
	30-91502-9	. . STRUCTURE ASSEMBLY, OBSERVER SEAT RH -V70203P		1		1
-108	NAS77-4-10	. . . BUSHING, NOT USED ON 30-91502-9		1		1
-109	30-91546-7	. . . BUSHING, STRUCTURE NOT USED ON 30-91502-7 -V70203P		1		1
-110	30-91502-11	. . . STRUCTURE, OBSERVER SEAT LH -V70203P		1		1
	30-91502-13	. . . STRUCTURE, OBSERVER SEAT RH -V70203P		1		1
-111	30-91511-1	. FOOTREST ASSEMBLY, OBSERVER'S SEAT FOR DETAIL BREAKDOWN SEE 25-1-3 FIGURE 2 -V70203P		1		1


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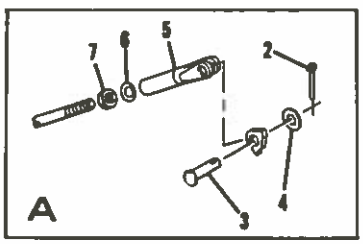

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
2-	30-91511-1	FOOTREST ASSEMBLY, OBSERVER SEAT FOR NHA SEE 25-1-3 FIGURE 1 -V70203P		1		REF
-1	30-91511-7	. COVER, OBSERVER SEAT FOOTREST RIVETED -V70203P		1		1
-2	AN380-2-1	. PIN		1		4
-3	MS20392-2-11	. PIN		1		4
-4	AN960-10L	. WASHER		1		4
-5	AN665-21R	. TERMINAL		1		4
-6	AN315-3	. NUT		1		4
-7	30-91511-9	. ROD, OBSERVER SEAT FOOTREST -V70203P		1		2
-8	30-91526-1	. LINK ASSEMBLY, SUPPORT FOOTREST -V70203P		1		2
		ATTACHING PARTS				
-9	97-61504-007	. RING -V70203P		1		2
-10	30-91543-7	. PIN, FOOTREST -V70203P		1		2
-11	NAS43HT3-39	. SPACER		1		2
-12	AN960-10	. WASHER		1		2
-13	AN960-10L	. WASHER		1		2
-14	NAS623-3-17	. BOLT		1		2
-15	AN960-10	. WASHER		1		4
-16	AN960-516L	. WASHER		1		4
-17	NAS679A3	. NUT		1		2
		- - - - X - - - -				
	30-91527-1	. FITTING ASSEMBLY, FOOTREST -V70203P		1		2
		ATTACHING PARTS				
-18	NAS623-3-15	. SCREW		1		4
-19	AN960-10L	. WASHER		1		4
-20	AN960-10	. WASHER		1		4
-21	NAS679A3	. NUT		1		4
		- - - - X - - - -				
-22	NAS75-3-30	. . BUSHING		1		1
-23	30-91527-7	. . FITTING, FOOTREST -V70203P		1		1
	30-91532-1	. LEG ASSEMBLY, FOOTREST LH -V70203P		1		1
	30-91532-2	. LEG ASSEMBLY, FOOTREST RH -V70203P		1		1
		ATTACHING PARTS				
-24	NAS623-3-13	. BOLT		1		2
-25	NAS75-3-24	. BUSHING		1		2
-26	AN960-10	. WASHER		1		4
-27	AN960-516L	. WASHER		1		4
-28	NAS679A3	. NUT		1		2
		- - - - X - - - -				
-29	NAS537-5-091	. . BUSHING		1		1
-30	NAS537-5-029	. . BUSHING		1		1
-31	30-91532-7	. . LEG, FOOTREST - V70203P		1		1
-32	30-91513-1	. FOOT PAN ASSEMBLY, OBSERVER SEAT -V70203P		1		1

CONVAIR MODEL 30

OVERHAUL MANUAL

Chapter 25

FLIGHT ENGINEER'S SEAT
(Convair Part No. 22-98505-3)

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Chapter 25-1-2

FLIGHT ENGINEER'S SEAT
(Convair Part No. 22-98505-3)

1. Description and Operation

A. Physical Description (See figure 1).

(1) The flight engineer's seat, part number 22-98505-3, consists of four major components: The base assembly, the back section of the upper structure assembly, the bottom section of the upper structure assembly, and the three control systems.

(2) The flight engineer's seat is adjustable in three directions: Vertical, horizontal and swivel. The seat is mounted on a track attached to the floor of the flight compartment to allow a front-to-back (horizontal) movement. Armrest assemblies are adjustable vertically.

(3) An inertia reel and shoulder harness are built into the flight engineer's seat.

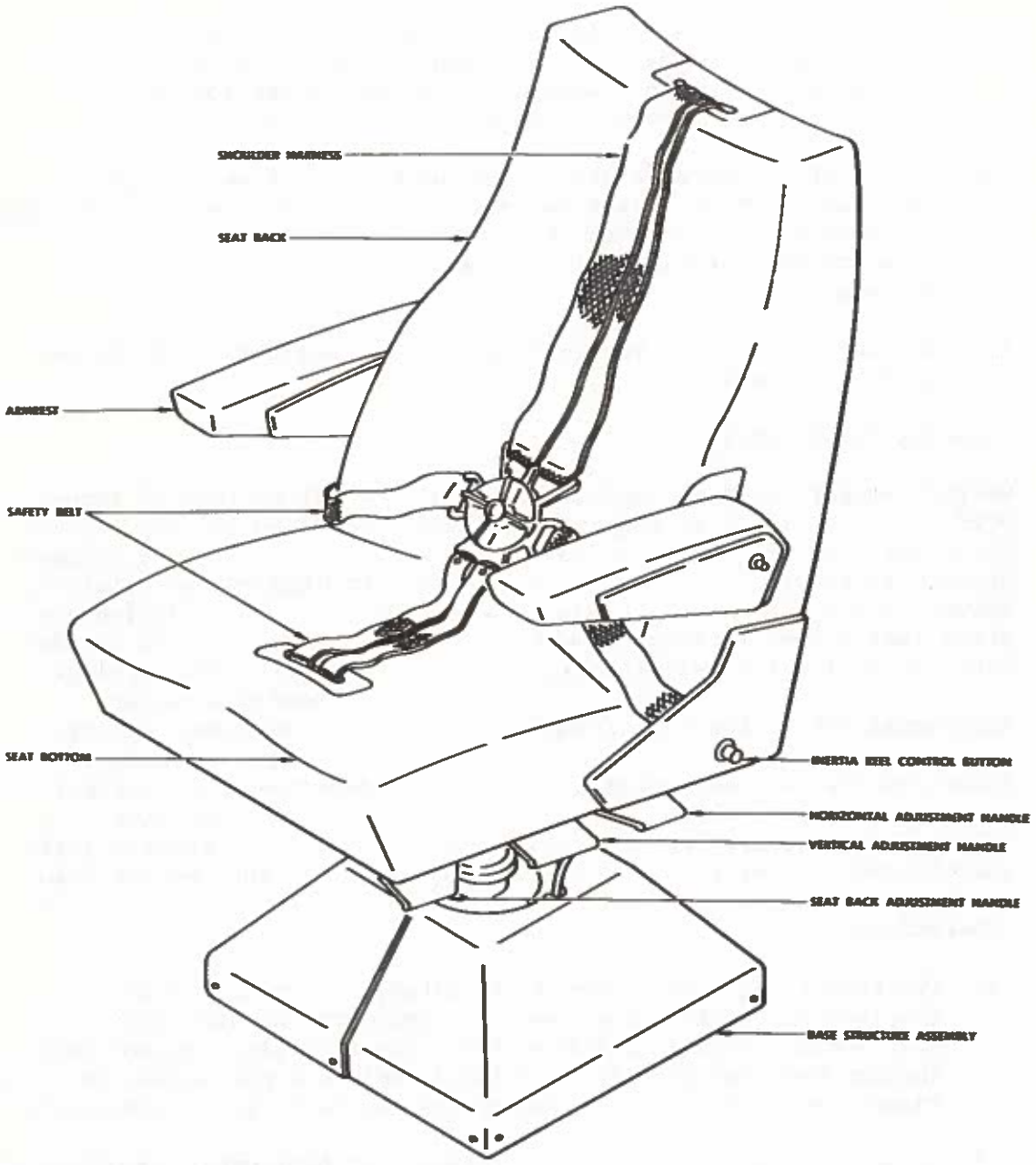
B. Leading Particulars.

Overall height (seat in lowest position)	38.60 (±0.25) inches
Overall height (seat in highest position)	43.60 (±0.25) inches
Total vertical travel	5 inches
Horizontal travel	Limited by installation
Swivel radius	215 degrees
Total seat weight (without track)	52 pounds
Vertical motivation (adjusting)	Hand operated, spring-loaded actuator
Horizontal motivation (adjusting)	Hand operated, spring-loaded actuator
Swivel motivation (adjusting)	Hand operated, spring-loaded actuator
Safety belt installation	Inertia reel
Inertia reel capacity	1800 pounds load

C. Operation.

(1) The flight engineer's seat is adjustable in front-to-back (horizontal) positioning, vertical positioning, and swivel positioning (through 215 degrees). These adjustments are made through hand-operated spring-loaded cable-and-pin actuators. Three control handles are located on the left side of the seat.

(2) To adjust seat height, swivel location or horizontal location, lift the proper handle and move the seat to the desired location. Release the handle and allow indexing pin to slip into lock-hole.



Flight Engineer's Seat, Perspective
Figure 1

(3) To fit the shoulder harness, pull on shoulder straps until desired location is obtained. Then, press the inertia reel button. When a sudden pull is exerted against the straps, the inertial reel will allow the straps to travel freely to the pre-set point. The inertia reel automatically unwinds and rewinds to allow free body movement.

2. Disassembly

The disassembly procedure outlined in the following steps will result in the complete disassembly of the flight engineer's seat. Welded and riveted assemblies are not disassembled. Numbers following part names refer to index numbers in the illustrated parts catalog (IPC).

A. (See IPC Figure 1.) Detach reel and shoulder harness (1) by unsnapping and lifting seat back upholstery assembly, and removing four nuts (2), one washer (3), three washers (4), one bolt (5), two bolts (6) and one bolt (7). Detach reel from inertia reel control assembly as described in paragraph 2.D.

B. Unsnap and remove back muslin cover (8) and seat back upholstery assembly (9).

NOTE: Remove cushion assembly (10) and filler (11) only if repairs are needed or replacement is anticipated.

C. Unsnap and remove bottom muslin cover (12) and seat bottom upholstery assembly (13).

NOTE: Remove cushion assembly (14) and filler (15) only if repairs are needed or replacement is anticipated.

D. Inertia Reel Control Assembly.

(1) Remove pin (16) to release clevis (21), spacer (17) and spring (20).

(2) Remove pin (18) to release spacer (19) and spring (20).

(3) Remove cotter pin (22), washer (23) and pin (24) to release inertia control rod assembly (25) and inertia reel control assembly (26). Unscrew clevis (21) from rod assembly (25).

(4) Remove washers (27) and pins (28) to release inertia reel control assembly (26) from reel and shoulder harness assembly (1).

(5) Remove three cotter pins (29), washers (30) and pins (31) to disconnect two crank assemblies (32) and rod assembly (33) from link assembly (34).

(6) Unscrew inertia reel button (35) from rod assembly (33).

(7) Remove nut (38) and spring (39) from rod assembly (33).

E. Unsnap left-hand upper seat fairing assembly (40) and unscrew locknut (36) to remove bezel (37). Unsnap right-hand upper seat fairing assembly.

F. Detach safety belt (42) by removing two nuts (43), washers (44) and screws (45).

G. Armrests.

(1) Lift left armrest to vertical position. Reach into armrest through slot with screwdriver, trip hinge on bracket assembly (58) and pull armrest assembly straight away from the seat assembly.

(2) Hold armrest index pin (51) and unscrew the armrest vertical adjustment button (47) by turning button counterclockwise.

(3) Remove armrest index pin spring (48), index cup (49), and armrest index pin (51).

(4) Remove armrest fairing (67) by loosening eight screws (66).

(5) Remove armrest upholstery (54) and cushion assembly (55) from shell assembly (64) only if repairs are necessary.

(6) Detach armrest fairing bracket assembly (58) and armrest adjustment spindle guide (72) from seat frame by removing two screws (69) and washers (70).

(7) Slide armrest adjustment spindle (68) off armrest adjustment spindle guide (72).

(8) Disassemble right armrest following steps (1) through (7).

H. Remove base fairing assemblies (73) by removing four screws (76) at base and four screws (75) and speednuts (74) located where parts overlap.

I. Swivel Control.

(1) Remove swivel control handle (83) and tube (79) by removing screw (77) and bolt (78).

(2) Remove control clevis (88) from control handle (83) by removing cotter pin (84), washer (86) and pin (87). Detach clevis from swivel cable assembly (112) by removing nut (85). Detach clevis from tube (92) by removing nut (89), washer (90) and screw (91).

(3) Detach swivel cable assembly (112) from upper structure assembly by removing nut (113), washer (114) and bolt (115).

(4) Loosen nuts on swivel cable assembly (112) and remove spring (111) and index pin (110).

J. Remove horizontal control handle (93); spring (99); vertical control handle (100) and attaching nut (101), washer (102) and screw (103); bellcrank assembly (104) and attaching cotter pin (105), washer (107) and pin (108) from tube (92). Remove tube (92) and two bushings (159) through which tube is mounted on upper structure assembly (133).

K. Horizontal Control.

(1) Disconnect horizontal control clevis (98) from horizontal control handle (93) by removing cotter pin (94), washer (96) and pin (97). Detach clevis from horizontal cable assembly (120) by removing nut (95).

(2) Detach horizontal cable assembly (120) from upper structure assembly by removing nut (121), washer (122) and bolt (123).

(3) Disconnect clevis (119) by removing cotter pin (116), washer (118) and pin (117). Loosen nuts on horizontal cable assembly (120) and detach clevis (119).

L. Vertical Control.

(1) Disconnect clevis (109) from vertical cable assembly (129) by removing nut (106).

(2) Detach vertical cable assembly (129) from upper structure assembly by removing nut (130), washer (131) and bolt (132).

(3) Loosen nuts on vertical cable assembly (129) to remove spring (128) and release clevis (127).

(4) Detach clevis (127) from bellcrank assembly (185) by removing cotter pin (124), washer (126) and pin (125).

M. Remove seat roller (134) from seat upper structure assembly (133) by removing nut (135), washer (136) and bolt (137). Remove grommet (138).

N. Remove seat spacer (139) and nut (140), washer (141) and stud (142).

O. Disassemble upper structure assembly components (143) through (171) only if structure components are to be replaced or repaired.

P. Detach upper structure assembly (133) from base assembly (174) by removing locknut (183) and set screw (184). Remove spring (172) and spring discs (173) from tube (167).

Q. Base Assembly.

(1) Detach two bushings (200) by removing two screws (199), washers (198) and nuts (197).

NOTE: These parts must be removed at this point to allow access to screw attaching vertical and swivel control assembly.

(2) Detach vertical and swivel control assembly (176) by removing two nuts (178), washers (180) and bolts (182); and six nuts (177), washers (179) and bolts (181).

(3) Detach vertical control index pin (192) by removing cotter pin (186), washer (187) and pin (188).

(4) Detach bellcrank assembly (185) by removing cotter pin (189), washer (190) and pin (191).

(5) Detach two track lock assembly pins (231) by removing cotter pin (227), washer (228) and pin (229).

(6) Detach two blocks (232) by removing two nuts (233), washers (234), screws (235) and screws (208) from each block.

R. Horizontal Control Assembly.

(1) Remove nuts (206), washers (207), screws (208) and rivets securing supports (205) to base assembly (174). Remove supports with bushings (209).

(2) Remove nuts (212), washers (213) and screws (214) securing two bellcrank assemblies (211) to tube (226).

(3) Remove nuts (221), washer (223) and screw (225) securing one end of spring (220) to bracket, and nut (221), washer (222) and screw (224) securing opposite end of spring to tube (226).

(4) Remove nuts (216), washers (217) and screws (218) securing bellcrank assembly (215) to tube (226) and slide out tube. Remove bushings (219) from brackets.

S. Gripper Assemblies.

(1) Detach each gripper assembly (237) by removing two bolts (175).

(2) Remove bushing (241) from each gripper assembly by removing nut (238), washer (239) and screw (240).

(3) Detach roller (242) and bushing (248) from each gripper (249) by removing nut (243), washer (244), two spacers (245), bolt (246) and woodruff key (247) from each gripper.

NAVIGATOR AND RADIO OPERATOR SEAT
(Convair Part No. 31-98506-5)

ATA NO. 25-1-5

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 30-5, Airplane Nos. 3, 4, and 25; 30-6 and 30-8

Aug. 15/63

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2. Disassembly

A. Seat Assembly. (See IPC Figure 1.)

(1) Unsnap and remove fairing assemblies (1).

(2) Unsnap and remove bottom cushion upholstery assembly (2). Remove bottom cushion assembly (3).

NOTE: Remove bottom filler (4) only if necessary for repair or replacement.

(3) Unfasten belt (5) from sides of seat. Remove crotch strap by removing two screws (6), two washers (7) and two nuts (8).

(4) Unsnap and remove back upholstery assembly (9).

NOTE: Remove seat back cover (10), bonded backrest cushion assembly (11) and backrest filler (12) only if necessary for repair or replacement.

(5) To disassemble armrest installation:

(a) Remove armrest assembly from seat by raising to vertical position and compressing spring loaded hinge (27), which bears against adjustment spindle (17), and sliding armrest assembly off of spindle (17).

(b) Remove armrest fairing bracket assembly (13) and spindle guide (16) by removing two screws (14) and two washers (15). Slide armrest adjustment spindle (17) from spindle guide (16).

(6) To disassemble armrest assembly:

(a) Remove lower armrest fairings (18) by removing eight screws (19). Remove armrest upholstery (20) by tearing loose cemented bottom edges.

NOTE: Remove armrest cushion assembly (21) only if necessary for repair or replacement.

(b) Unscrew the armrest vertical adjustment button (22) in counter clockwise direction and remove the armrest index pin spring (23), armrest index pin (24) and deep drawn armrest vertical adjustment cup (25) from the armrest shell assembly (30). Remove bushing (28).

NOTE: Remove bracket (29), hinge (27) and spring (26) only if necessary for replacement.

(7) Remove forward and rear seat base fairings (47) and (48) by removing eighteen screws (49) and four nuts (50).

(8) Detach cables (60) from upper seat structure by removing two bolts (51), two washers (52), two nuts (53), two pins (54), pin (55), pin (56), two washers (57), two control clevises (58), and two nuts (59).

(9) Detach cables (60) from base assembly by removing pin (54), pin (55) and washer (57). Unscrew clevis (58). Remove spring (61). Unscrew locknut (detail of cable 60). Unscrew swivel index pin (63). Remove spring (62). Unscrew locknut (detail of cable 60) and remove cables (60).

(10) Remove screw (64), bolt (65), lever tube assembly (66) and tapered crank handle (67). Remove vertical control bellcrank assembly (68) by removing screw (69), washer (70) and nut (71). Remove screw (72), washer (73), nut (74), lever torque tube (75) and tapered plain handle (76). Remove bushings (45).

(11) Remove inertia reel (77) by removing six bolts (78) and six washers (79).

(12) Remove belt stop rod (33) by removing two pins (31) and two washers (32).

(13) Remove roller (34) by removing bolt (35), washer (36) and nut (37).

NOTE: Remove grommet (38) only if necessary for replacement.

(14) (See IPC Figure 2.) Remove guide screw (4) and nut (5) from vertical and swivel control assembly. Remove seat assembly from base assembly.

(15) (See IPC Figure 1.) Remove spring (81) and spring disc (80).

B. Base Assembly. (See IPC Figure 2.)

(1) Remove vertical and swivel control assembly by removing ten screws (1), ten washers (2) and ten nuts (3).

(2) Disassemble vertical and swivel control assembly by removing two screws (6), two bushing (7), two washers (8) and two nuts (9).

(3) Remove pin (10), pin (11) and washer (12) from metering pin (14). Remove bellcrank (13) by removing pin (15), pin (16) and washer (17).

3. Cleaning

A. General.

(1) Use soap and water to clean covers while installed over foam, as cleaning solvents are injurious to foam rubber.

(2) Use any standard commercial dry cleaning procedure on a cover which has been removed.

(3) Use soap and water to clean foam rubber, boltron fairings and naugahide covers.

(4) Clean metal parts contaminated with oil or grease with cleaning solvent specified in paragraph 6.C. (9) or equivalent.

WARNING: USE CLEANING SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND AVOID CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

B. Types of Cleaning Agents.

(1) No single type of cleaning agent is completely effective in the removal of all soiling; each product has its limitations. The instructions given on the product containers should be carefully followed to insure best results.

(2) Concentrated detergent preparations, commonly called upholstery shampoo, are effective in removing dry or waterborne soil. Recommended detergent preparations are specified in paragraph 6. C. (1), (2), (3) and (4).

(3) Solvent type cleaning agents are effective in removal of oil type soil or grease spots. Recommended solvent type cleaning agents are specified in paragraph 6. C. (5), (6) and (7). Solvent impregnated powder, specified in paragraph 6.C. (8), may be used instead of solvent cleaning agents.

C. Cleaning Procedure.

(1) Vacuum upholstery thoroughly, or brush with a medium stiff bristle upholstery or clothing brush. Do not pound or beat.

(2) Test material to be cleaned by first applying cleaning agent to a small obscure area of material.

(3) Use solvent type cleaning agent or solvent impregnated powder to remove oil-type soil or grease stains. Use cleaning material sparingly, without saturating fabric, to avoid damage to foam.

Apply cleaning agent with a clean soft cloth and avoid spreading any stains by working from the outer edges toward the center.

WARNING: WORK IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS. KEEP AWAY FROM OPEN FLAMES.

NOTE: Solvents should be evaporated rapidly from the fabric surface by directing an air stream from a vacuum cleaner, or by fanning, toward material to avoid formation of rings.

4. Inspection

A. General.

Where doubt exists concerning serviceability of standard AN, NAS, and MS parts, the part should be renewed.

B. Visual Inspection.

Under strong light, preferably under magnification, visually inspect all parts as applicable for scored or stripped threads, cracks, nicks, scratches, dents, corrosion and excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of parts.

C. Dye Penetrant Inspection.

Refer to Military Specification MIL-I-6866.

D. Magnetic Particle Inspection.

Refer to Military Specification MIL-I-6868.

E. Component Inspection.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
1-1, 1-47	Fairings	Visual - scuffs, cracks, loose snaps, loose rivets.
1-2, 1-9, 1-20	Upholstery	Visual - cleanliness, tears, wear, holes.
1-3, 1-11, 1-21	Cushion	Visual - cleanliness, tears, deterioration.
1-4, 1-12	Filler	Visual - cracks, breaks.
1-5	Belt	Visual - cleanliness, wear, damage.
1-10	Cover	Visual - cleanliness, tears, wear, holes.
1-13	Bracket assembly	Visual - cracks, distortion, damage, holes out of round.
1-16	Guide	Visual - check plating, distortion, holes out of round.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
1-17	Spindle	Visual - distortion, breaks, cracks, holes out of round.
1-18	Fairing	Visual - damage, holes out of round.
1-22	Button	Visual - check paint, damage to threads.
1-24	Pin	Visual - straightness, damage to threads.
1-30	Shell	Visual - distortion, loose rivets, holes out of round.
1-33	Rod	Visual - distortion, out of round.
1-34	Roller	Visual - wear, out of round.
1-38	Grommet	Visual - deterioration.
1-46	Structure	Visual - cracks, loose rivets.
1-58	Clevis	Visual - distortion, elongation of holes.
1-63	Pin	Visual - straightness, distortion, out of round.
1-66	Tube assembly	Visual - chips, loose inserts.
1-67, 1-76	Handle	Visual - chips, loose inserts.
1-68	Bellcrank assembly	Visual - cracks, distortion, elongated holes.
1-75	Tube	Visual - cracks, distortion, elongated holes, out of round.
1-80	Disc	Visual - chips and separation of laminations.
2-13	Bellcrank	Visual - cracks, distortion, elongated holes.
2-14	Pin	Visual - distortion, elongated holes, out of round.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
2-21	Post assembly	Visual - cracks, distortion.
2-22	Fairing assembly	Visual - distortion, cracks, loose rivets.
2-23	Spider assembly	Visual - cracks, distortion, loose rivets.

F. Special Inspection of Components.

IPC FIGURE AND INDEX NO.	NOMENCLATURE	INSPECTION
1-23	Spring	Free length 1.6 inches. Visual - check plating. Magnetic particle inspection refer to paragraph 4.D.
1-25	Cup	Visual - distortion, out of round. Magnetic particle inspection refer to paragraph 4.D.
1-26	Spring	Visual - check plating. 6 ½ coils torsion. Magnetic particle inspection refer to paragraph 4.D.
1-61	Spring	Free length .75 inches. Visual - check plating. Magnetic particle inspection refer to paragraph 4.D.
1-62	Spring	Free length 1.60 inches. Visual - check plating. Magnetic particle inspection refer to paragraph 4.D.
1-81	Spring	Free length 15.25 inches. Visual - check plating. Magnetic particle inspection refer to paragraph 4.D.

5. Repair

A. General.

(1) Minor nicks and scratches may be removed from aluminum alloy parts by polishing with oxide abrasive cloth specified in paragraph 6. C. (13) or equivalent. Clean all parts thoroughly after polishing.

(2) Minor nicks and scratches may be removed from non-critical steel parts by polishing with crocus cloth specified in paragraph 6.C. (14) or equivalent. Clean all parts thoroughly after polishing.

(3) Use standard shop practice for minor repair of sheet metal and/or riveted pieces.

(4) Components not satisfying inspection requirements must be repaired before seat is returned to service or storage. Repairs are listed in the following paragraphs. Components which require inspection and are not listed in these paragraphs should be renewed if damaged or worn.

B. Cemented Foam. (See IPC Figure 1.)

(1) All foam pads except removable seat pad (3) are cemented to the metal structure. The cemented joint normally is stronger than the foam itself and usually will be damaged beyond use during removal operations. Foam damaged during removal should not be reinstalled. Short sections of the cemented joint can be opened and recemented.

(2) To remove foam for renewal, use sharp thin knife to cut the foam close to the cemented joint while pulling foam away from the structure. Most of the foam should come off, leaving a thin layer of foam and cement on metal. If a relatively even surface is obtained, new foam may be installed over this thin layer. If the layer is thick or uneven, strip down to bare metal before installing new foam. Use commercial grade acetone as solvent to soak layer before using a dull metal blade to scrape layer from metal.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

CAUTION: ACETONE CAUSES FOAM BREAKDOWN. DO NOT USE ACETONE IN MAKING MINOR REPAIRS. DO NOT RE-USE FOAM SOAKED BY ACETONE.

(3) If foam is torn or loose, but is otherwise usable, cement the tear or the loose joint. Apply cement specified in paragraph 6. C. (10), or equivalent, to both sides of joint and allow to air dry until tacky. Press joint together and hold briefly.

NOTE: There is some local stiffening of foam at cemented joints. Avoid heavy or extensive cementing on seat foam surfaces or edges.

6. Assembly

A. Base Assembly. (See IPC Figure 2.)

(1) Assemble vertical and swivel control assembly. Attach bellcrank (13) to metering pin (14) with pin (11), washer (12), and pin (10). Insert metering pin (14) into metering hole in plate assembly and install bellcrank (13) with pin (16), washer (17) and pin (15).

NOTE: Sleeve (18), plate assembly (19) and ring (20) should not have been disassembled.

(2) Attach two bushings (7) with two screws (6), two washers (8) and two nuts (9). Start cam screw (4) and locknut nut (5).

(3) Attach vertical and swivel control assembly to center post assembly (21) with ten screws (1), ten washers (2) and ten nuts (3). Spider assembly (23) and fairing assemblies (22) are riveted to center post assembly.

B. Seat Assembly. (See IPC Figure 1.)

(1) Insert spring disc (80) and spring (81) into seat base assembly (82). Place seat assembly on base assembly.

(2) (See IPC Figure 2.) Pull metering pin (14) to allow seat assembly tube to pass over spring and into base assembly. Insert metering pin (14) into metering holes in seat assembly tube. Screw cam screw (4) through base assembly into guide slot in seat assembly tube. If screw (4) will not enter slot, hold seat assembly down and pull metering pin (14). Screw cam screw (4) into slot. Screw locknut (5) onto cam screw (4).

NOTE: Cam screw (4) adjustment will have to be performed after final assembly.

(3) (See IPC Figure 1.) Install grommet (38) if removed.

(4) Attach roller (34) with bolt (35), washer (36) and nut (37).

(5) Attach belt stop rod (33) with two washers (32) and two pins (31).

(6) Attach inertia reel (77) with six washers (79) and six bolts (78).

(7) Install two bushings (45).

(8) Insert torque lever tube (75) into tapered plain handle (76) and attach with screw (72), washer (73) and nut (74). Add vertical control bellcrank assembly (68) with screw (69), washer (70) and nut (71).

(9) Insert lever tube assembly (66) into tapered crank handle (67) and attach tube with screw (64) and bolt (65).

(10) Attach two cables (60) to base assembly with locknuts (details of cables 60). Install spring (62) and screw on swivel index pin (63). Install spring (61) and screw on clevis (58). Attach clevis to base assembly with pin (55), washer (57) and pin (54).

(11) Attach cables (60) to upper seat structure with two nuts (59), two control clevises (58), pin (55), pin (56), two washers (57) and two pins (54), two bolts (51), two washers (52) and two nuts (53).

(12) Attach forward and rear seats base fairings (47) and (48) with eighteen screws (49) and four nuts (50).

(13) To assemble armrest assembly:

(a) Install spring (26) to hinge (27) and attach hinge (27) to brackets (29) with rivets if removed for repair or replacement.

(b) Attach brackets (29) to armrest shell assembly (30) with rivets if removed for repair or replacement. Install bushings (28).

(c) Insert deep drawn armrest vertical adjustment cup (25) into armrest shell (30). Insert spring (23) into cup (25) and install armrest index pin (24) through spring (23) and cup (25). Screw on armrest vertical adjustment button (22) in clockwise direction.

(d) Replace armrest cushion assembly (21) if removed for repair for replacement.

(e) Replace armrest upholstery (20) by cementing bottom edges to armrest shell assembly (30). Attach lower armrest fairings (18) with eight screws (19).

(14) To assemble armrest installation:

(a) Slide armrest adjustment spindle (17) onto spindle guide (16). Attach armrest fairing bracket assembly and spindle guide (16) with two screws (14) and two washers (15).

(b) Install armrest assembly by slipping armrest onto spindle (17) until hinge (27) holds armrest onto structure.

(15) Attach backrest filler (12), backrest cushion assembly (11) and backrest cover (10) if removed for repair or replacement.

(16) Attach back upholstery assembly (9) by fastening the snaps around bottom edge.

(17) Fasten belt (5) to sides of seat and attach crotch straps with two screws (6), two washers (7) and two nuts (8).

(18) Attach bottom filler (4) if removed for repair or replacement.

(19) Install bottom cushion assembly (3) and snap on bottom cushion upholstery assembly (2).

(20) Snap on fairing assemblies (1).

(21) (See IPC Figure 2.) Adjust cam screw (4) so seat will meter vertically at each metering adjustment increment. Lock cam screw (4) with nut (5).

C. Materials.

Use materials recommended or equivalents.

MATERIAL	IDENTIFICATION	SOURCE
(1) Upholstery cleaner	Foam Cleaner	E.I. Du Pont De Nemours & Co., (Inc.) Wilmington, Delaware
(2) Upholstery cleaner	Glamorene	Glamorene Incorp., 270 Park Ave. New York, New York
(3) Upholstery cleaner	Mystic Foam	Mystic Foam Corp., Cleveland, Ohio
(4) Upholstery cleaner	Duo-Dellay	Duo-Dellay Products Co., 4201 Puleshi Highway Baltimore, Maryland
(5) Upholstery cleaner	Du Pont Dry Clean	E.I. Du Pont De Nemours & Co., (Inc.) Wilmington, Delaware
(6) Upholstery cleaner	Carbone Instant Foam Lather	Carbone Corporation, 30-50 Greenpoint Ave., Long Island City 1, New York

MATERIAL	IDENTIFICATION	SOURCE
(7) Upholstery cleaner	Carbone Cleaning Fluid	Carbone Corporation, 30-50 Greenpoint Ave., Long Island City 1, New York.
(8) Upholstery cleaner	Powder-ene	Von Schroder Manufacturing Co., Racine, Wisconsin.
(9) Cleaning solvent	Federal Specification P-S-661	Optional
(10) Cement	EC-1300	3-M Corporation, St. Paul, Minnesota.
(11) Cement	Rubber to Metal T-161 Sta-Bond	American Latex Products Corp., 3341 W. El Segundo Blvd., Hawthorne, California.
(12) Cement	Rubber to Rubber H-125 Sta-Bond	American Latex Products Corp., 3341 W. El Segundo Blvd., Hawthorne, California.
(13) Abrasive cloth	No.600 to 800 grade. Federal Specification P-C-451	Optional
(14) Crocus cloth	Federal Specification P-C-458	Optional
(15) Wrapping paper	Federal Specification UU-P-271	Optional
(16) Tape	Federal Specification JAN-P-127	Optional

7. Fits and Clearances

Check for five (5) thousandths clearance between ring (20) and plate assembly (19) if ring does not let plate assembly rotate.

8. Testing

A. Safety Belts.

Test to current F. A. A. requirements.

B. Seat Operation.

(1) Sit in seat. Raise and lower armrests. Armrests should lock in all vertical metered positions.

(2) Raise forward control handle. This moves control pin to unlock position. Release handle and check pin for complete return. Raise handle to full-up position. Seat should swivel for one hundred ninety-one degrees. Release handle at each metered position to check meter alignment. Check pin for complete return in each position.

(3) Raise aft control handle. This moves vertical control pin to unlocked position. Release handle and check pin for complete return. Raise handle to full-up position.

(4) Stand in front of seat. Pull shoulder harness straps sharply (over 3 G's). Reel should lock. Release straps. Reel will unlock automatically.

NOTE: Test each strap separately.

9. Trouble Shooting

NAVIGATOR AND RADIO OPERATOR SEAT ASSEMBLIES
TROUBLE SHOOTING

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
A. ARMREST DOES NOT MOVE OR IT BINDS.	
(1) Armrest adjustment spindle (17) will not slide on armrest adjustment spindle guide (16).	Check for foreign material, paint, tape, burrs, scoring and distortion. Clean or replace.
B. ARMREST WILL NOT MOVE TO STOWED POSITION.	
(1) Bracket assembly (29) will not turn in armrest adjustment spindle (17).	Check for scored parts and galling. Clean or replace spindle (17).
C. ARMREST FALLS OFF.	
(1) Hinge assembly (27) fails to fasten armrest. Spring (26) could be broken.	Check hinge (27) and spring (26). Replace spring (26) if broken.
D. SWIVEL CONTROL DOES NOT WORK FREELY.	
(1) Tapered crank handle (67) sticks.	Check for distorted bellcrank on handle (67). If distorted, replace.
(2) Control cable (60) sticks.	Check for crimped cable. Check for scored cable ends. Replace if necessary.
(3) Control clevis (58) sticks.	Check for distortion. Replace if necessary.
(4) Control spring (62) weak.	Replace spring.
(5) Swivel index pin (63) bent.	Replace pin.
(6) Swivel index pin (63) out of round.	Replace pin.
(7) Cable adjustment on end of cable (60) not adjusted properly.	Readjust.

NAVIGATOR AND RADIO OPERATOR SEAT ASSEMBLIES
TROUBLE SHOOTING (CONT.)

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
E. VERTICAL CONTROL DOES NOT WORK FREELY.	
(1) Torque tube (75) binds in bushings (45).	Check for paint, bushing out of round, chips and foreign material. Clean and ream bushing (45) to remove burrs. Replace if necessary. Check torque tube (75) for straightness and out of round. Straighten or replace.
(2) Control handle (76) loose on torque tube (75).	Check holes for elongation. If so, replace both handle (76) and torque tube (75).
(3) Bellcrank (68) loose on torque tube (75).	Check holes for elongation. Replace both bellcrank (68) and torque tube (75).
(4) Control clevis (58) binds.	Check for distortion. If so, replace. Check for elongated holes. Replace if necessary.
(5) Control cable (60) sticks or binds.	Check for crimped cable. Check cable ends for scores. Replace if necessary.
(6) Control spring (61) weak.	Replace spring (61).
(7) (See IPC Figure 2.) Bellcrank (13) binds.	Check bellcrank (13) for distortion and elongated holes. If distorted, straighten; if elongated holes, replace.
(8) Bellcrank (13) binds on pin (16).	Check pin (16) for straightness. Straighten or replace. Check bellcrank (13) for galled hole. If hole is galled, ream or replace.
(9) Metering pin (14) bent or distorted.	Check alignment and straighten if possible. Replace if necessary. Check for distorted clevis end and elongated holes. Replace if necessary. Check for scores and wear. Replace.

NAVIGATOR AND RADIO OPERATOR SEAT ASSEMBLIES
TROUBLE SHOOTING (CONT.)

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
F. VERTICAL AND SWIVEL CONTROL ASSEMBLY BINDS OR DOES NOT SWIVEL FREELY.	
(1) Ring (20) does not let plate assembly (19) rotate.	Check for five thousandths clearance between ring (20) and plate assembly (19). Replace assembly if necessary. Check for foreign material. Clean by blowing cleaning fluid into mechanism to remove machine oils. Rotate until free.
G. Vertical Metering Skips.	
(1) Adjustment cam screw (4) broken.	Replace.
(2) Adjustment cam screw (4) worn.	Remove screw and replace.
(3) Adjustment cam screw (4) is out of adjustment.	Readjust.
(4) Adjustment cam screw (4) not in far enough or in too far.	Visual inspection with aid of mirror or scale. Adjust screw to proper depth.

10. Storage Instructions

A. The seat assembly is essentially corrosion resistant and no special preservation is required.

B. Wrap seat in waterproof wrapping paper specified in paragraph 6.C. (15), or a plastic cover. Use tape specified in paragraph 6.C.(16), or equivalent, to secure wrapping paper,or cover. Stamp seat assembly part number and date of overhaul on a tag, or in a convenient location on seat wrapper.

C. Store seat in a cool dry area, below 68 degrees F., away from sunlight and heat source.

11. Special Tools, Fixtures and Equipment

No special tools, fixtures or equipment are needed for overhaul of the seat.

ILLUSTRATED PARTS BREAKDOWN

NAVIGATOR AND RADIO OPERATOR SEAT
(Convair Part No. 31-98506-5)

ATA NO. 25-1-5

Applicable to Models 30-5, Airplane Nos. 3, 4, and 25; 30-6 and 30-8

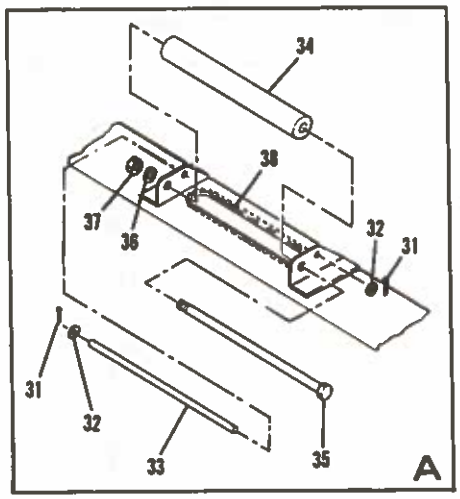
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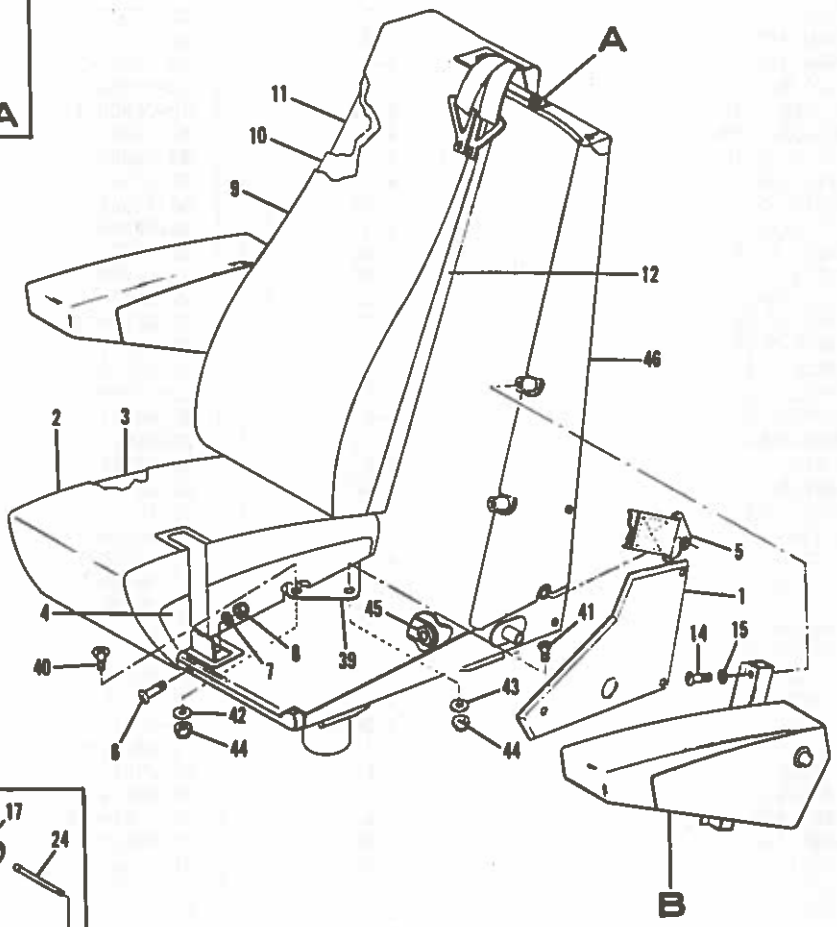
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AN960-10L		1-32	14
AN960-4		1-57	4
AN960-416		1-52	2
AN960-416L		2-2	10
AN960-8L		1-70	1
MS20392-1-12		2-11	1
MS20392-1-13		1-55	2
MS20392-1-19		1-56	1
MS20392-2-43		2-16	1
NAS1103-3		1-78	6
NAS1204-6		2-1	10
NAS488-10-3		1-50	4
NAS623-2-10		1-69	1
NAS623-2-2		1-19	16
NAS623-3-13		1-72	1
NAS623-3-16		1-6	2
NAS623-3-3		1-41	2
NAS623-3-4		1-14	6
NAS623-3-6		2-6	2
NAS679AO8		1-71	1
NAS679A3		1-8	6
NAS679A4		1-53	12
NAS77A8-09P		1-45	2
1101116-0		1-5	1
22-98350		1-75	1
22-98350-1		1-75	1
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22-98374		1-23	2
22-98375		1-81	1
22-98380		1-62	1
22-98512-2		1-1	1
22-98512-3		1-1	1
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22-98517-19		1-39	1
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22-98517-5		1-	1
22-98519-25		2-4	1
22-98519-27		2-7	2
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22-98562-2		1-	1
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22-98577		1-20	2
22-98579-1		1-18	2
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31-98511-9		1-48	1
31-98519-1		2-	1
31-98519-11		2-18	1
31-98519-13		2-20	1
31-98519-7		2-19	1
31-98529-1		2-23	1
40433-6		1-60	2
630B1002		1-61	1
95N		1-77	1


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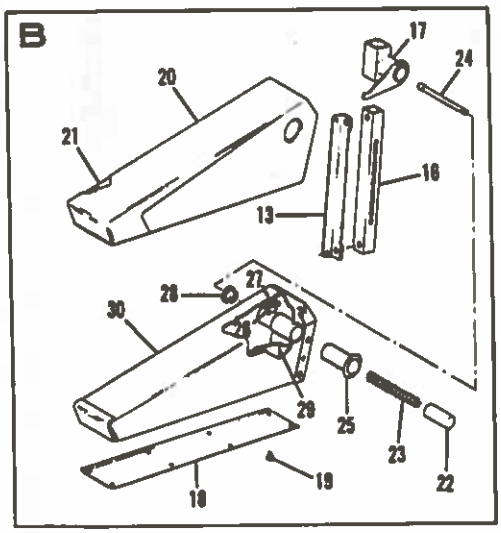
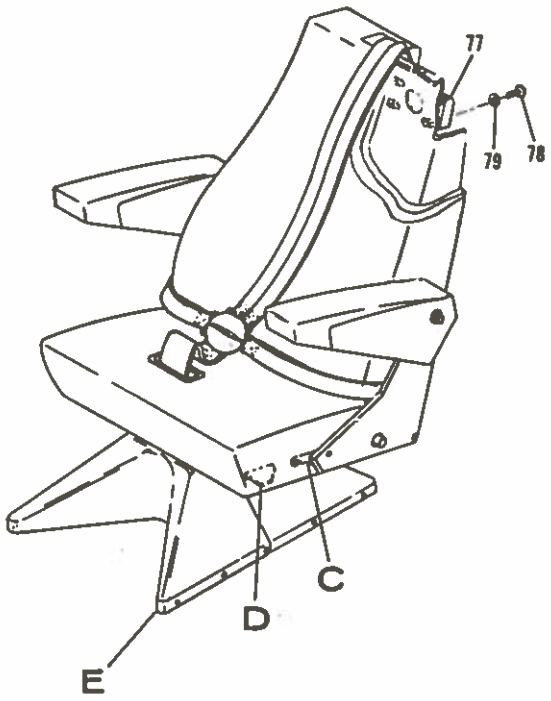
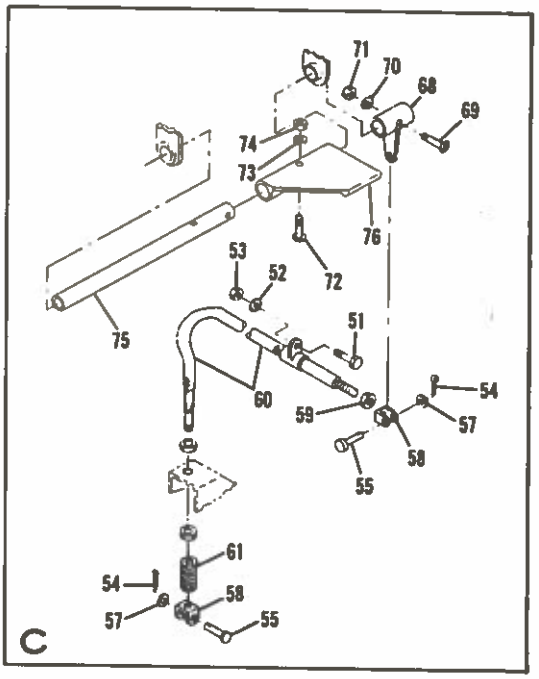
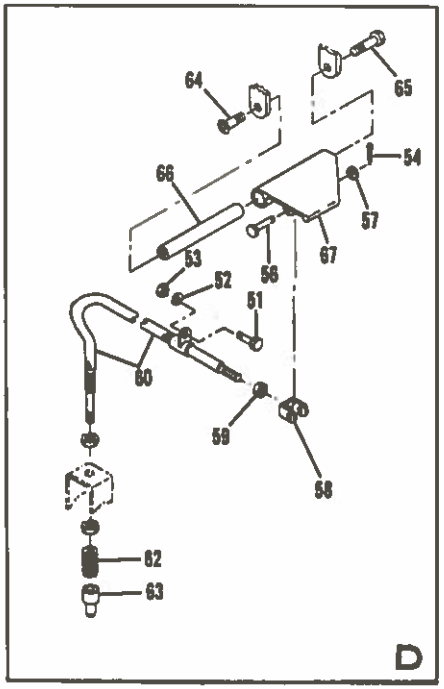

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1-	31-98506-5	SEAT ASSEMBLY, NAVIGATOR AND RADIO OPERATOR -V70203P		1	1
-1	22-98512-3	. FAIRING ASSEMBLY, UPPER LH -V70203P		1	1
	22-98512-2	. FAIRING ASSEMBLY, UPPER RH -V70203P		1	1
-2	22-98527	. UPHOLSTERY ASSEMBLY, BOTTOM CUSHION -V70203P		1	1
-3	22-98363-1	. CUSHION ASSEMBLY, BOTTOM -V70203P		1	1
-4	22-98523	. FILLER, BOTTOM -V70203P		1	1
-5	1101116-0	. BELT, CONVAIR 98-54800-004 -V45402		1	1
		ATTACHING PARTS			
-6	NAS623-3-16	. SCREW		1	2
-7	AN960-10	. WASHER		1	2
-8	NAS679A3	. NUT		1	2
		- - - - X - - - -			
-9	31-98357-1	. UPHOLSTERY ASSEMBLY, BACK -V70203P		1	1
-10	22-98366	. COVER, SEAT BACK -V70203P		1	1
-11	22-98524-5	. CUSHION ASSEMBLY, BACKREST -V70203P		1	1
-12	22-98525	. FILLER, BACKREST -V70203P		1	1
	22-98562-1	. ARMREST INSTALLATION, LH -V70203P		1	1
	22-98562-2	. ARMREST INSTALLATION, RH -V70203P		1	1
-13	22-98582	. . BRACKET ASSEMBLY, ARMREST FAIRING -V70203P		1	1
		ATTACHING PARTS			
-14	NAS623-3-4	. . SCREW		1	2
-15	AN935-10	. . WASHER		1	2
		- - - - X - - - -			
-16	22-98573-9	. . GUIDE, ARMREST ADJUSTMENT SPINDLE -V70203P		1	1
-17	22-98564-1	. . SPINDLE, ARMREST ADJUSTMENT LH -V70203P		1	1
	22-98564-2	. . SPINDLE, ARMREST ADJUSTMENT RH -V70203P		1	1
	22-98562-7	. . ARMREST ASSEMBLY, LH -V70203P		1	1
	22-98562-8	. . ARMREST ASSEMBLY, RH -V70203P		1	1
-18	22-98579-1	. . . FAIRING, ARMREST LOWER -V70203P		1	1
		ATTACHING PARTS			
-19	NAS623-2-2	. . . SCREW		1	8
		- - - - X - - - -			
-20	22-98577	. . . UPHOLSTERY ASSEMBLY, ARMREST -V70203P		1	1
-21	22-98576-3	. . . CUSHION ASSEMBLY, ARMREST LH -V70203P		1	1
	22-98576-4	. . . CUSHION ASSEMBLY, ARMREST RH -V70203P		1	1
-22	22-98568	. . . BUTTON, ARMREST VERTICAL ADJUSTMENT -V70203P		1	1
-23	22-98374	. . . SPRING, ARMREST INDEX PIN -V70203P		1	1
-24	22-98566	. . . PIN, ARMREST INDEX -V70203P		1	1
-25	22-98580	. . . CUP, DEEP DRAWN ARMREST VERTICAL ADJUSTMENT -V70203P		1	1
	22-98565-3	. . . BRACKET ASSEMBLY, LH WELDED -V70203P		1	1
	22-98565-4	. . . BRACKET ASSEMBLY, RH WELDED -V70203P		1	1
	22-98581	. . . . HINGE ASSEMBLY, RIVETED -V70203P		1	1
-26	22-98373	. . . . . SPRING, -V70203P		1	1
-27	22-98581-7	. . . . . HINGE, MAKE FROM MS20001-8-200 -V70203P		1	2
-28	22-98565-21	. . . . BUSHING, -V70203P		1	1
-29	22-98565-11	. . . . BRACKET, LH -V70203P		1	1
	22-98565-12	. . . . BRACKET, RH -V70203P		1	1
-30	22-98563-1	. . . SHELL ASSEMBLY, ARMREST LH -V70203P		1	1
	22-98563-2	. . . SHELL ASSEMBLY, ARMREST RH -V70203P		1	1

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1-	22-98517-5	STRUCTURE ASSEMBLY, UPPER SEAT -V70203P		1	1
-31	AN380-2-1	. PIN		1	2
-32	AN960-10L	. WASHER		1	2
-33	30-98506-7	. ROD, BELT STOP -V70203P		1	1
-34	22-98530-55	. ROLLER, -V70203P		1	1
		ATTACHING PARTS			
-35	AN3-77A	. BOLT		1	1
-36	AN960-10	. WASHER		1	1
-37	NAS679A3	. NUT		1	1
		- - - - X - - - -			
-38	22-98517-45	. GROMMET, -V70203P		1	1
-39	22-98517-19	. PLATE, -V70203P		1	1
		ATTACHING PARTS			
-40	NAS623-3-4	. SCREW		1	2
-41	NAS623-3-3	. SCREW		1	2
-42	AN960-10	. WASHER		1	2
-43	AN960-10L	. WASHER		1	2
-44	AN365-1032	. NUT		1	4
		- - - - X - - - -			
-45	NAS77A8-09P	. BUSHING		1	2
-46	22-98517-17	. STRUCTURE, UPPER SEAT -V70203P		1	1


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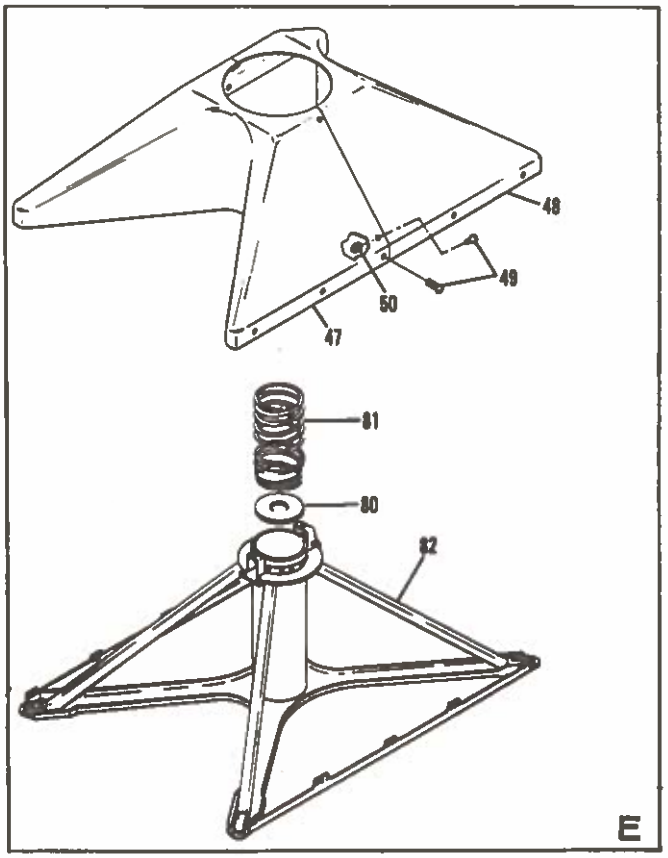
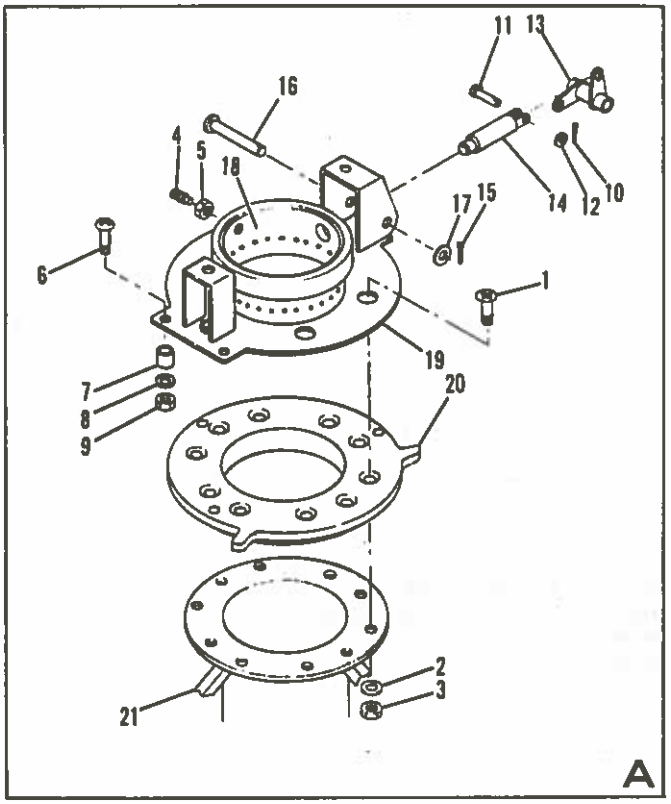

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1- -47	31-98511-7	. FAIRING, SEAT BASE FORWARD -V70203P		1	1
-48	31-98511-9	. FAIRING, SEAT BASE REAR -V70203P		1	1
		ATTACHING PARTS			
-49	AN525-10R7	. SCREW		1	18
-50	NAS488-10-3	. NUT		1	4
		- - - - X - - - -			
-51	AN4-4A	. BOLT		1	2
-52	AN960-416	. WASHER		1	2
-53	NAS679A4	. NUT		1	2
-54	AN380-2-1	. PIN		1	3
-55	MS20392-1-13	. PIN		1	2
-56	MS20392-1-19	. PIN		1	1
-57	AN960-4	. WASHER		1	3
-58	22-98595	. CLEVIS, CONTROL -V70203P		1	3
-59	AN315-3R	. NUT		1	2
-60	40433-6	. CABLE, CONVAIR 91-38006-001 -V80523		1	2
-61	630B1002	. SPRING, CONVAIR 98-36008-011 -V70203P		1	1
-62	22-98380	. SPRING, INDEX PIN -V70203P		1	1
-63	22-98368	. PIN, SWIVEL INDEX -V70203P		1	1
-64	AN525-10R6	. SCREW		1	1
-65	AN3-3A	. BOLT		1	1
-66	22-98351	. TUBE ASSEMBLY, LEVER -V70203P		1	1
-67	22-98548-7	. HANDLE, TAPERED CRANK -V70203P		1	1
-68	22-98354	. BELLCRANK ASSEMBLY, VERTICAL CONTROL -V70203P		1	1
		ATTACHING PARTS			
-69	NAS623-2-10	. SCREW		1	1
-70	AN960-8L	. WASHER		1	1
-71	NAS679A08	. NUT		1	1
		- - - - X - - - -			
-72	NAS623-3-13	. SCREW		1	1
-73	AN960-10L	. WASHER		1	1
-74	NAS679A3	. NUT		1	1
-75	22-98350-1	. TUBE, LEVER TORQUE ALTERNATE PART FOR 22-98350 -V70203P		1	1
	22-98350	. TUBE, LEVER TORQUE ALTERNATE PART FOR 22-98350-1 -V70203P		1	1
-76	22-98550	. HANDLE, TAPERED PLAIN -V70203P		1	1
-77	95N	. REEL, INERTIA CONVAIR 97-34505-001 -V83945		1	1
		ATTACHING PARTS			
-78	NAS1103-3	. BOLT		1	6
-79	AN960-10L	. WASHER		1	6
		- - - - X - - - -			
-80	22-98596	. DISC, SPRING -V70203P		1	1
-81	22-98375	. SPRING, VERTICAL ASSIST -V70203P		1	1
-82	31-98509-1	. BASE ASSEMBLY, NAVIGATOR AND RADIO OPERATOR FOR DETAIL BREAKDOWN SEE 25-1-5 FIGURE 2 -V70203P		1	1


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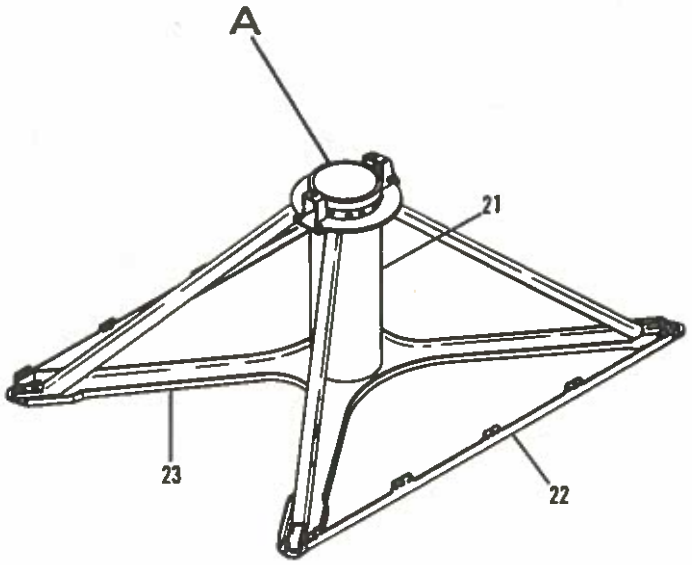

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
2-	31-98509-1	BASE ASSEMBLY, NAVIGATOR AND RADIO OPERATOR FOR NHA SEE 25-1-5 FIGURE 1 -V70203P		1	REF
	31-98519-1	. CONTROL ASSEMBLY, VERTICAL AND SWIVEL -V70203P		1	1
		ATTACHING PARTS			
-1	NAS1204-6	. SCREW		1	10
-2	AN960-416L	. WASHER		1	10
-3	NAS679A4	. NUT		1	10
		- - - - X - - - -			
-4	22-98519-25	. . SCREW, -V70203P		1	1
-5	AN316-6R	. . NUT		1	1
-6	NAS623-3-6	. . SCREW		1	2
-7	22-98519-27	. . BUSHING, -V70203P		1	2
-8	AN960-10L	. . WASHER		1	2
-9	NAS679A3	. . NUT		1	2
-10	AN380-2-1	. . PIN		1	1
-11	MS20392-1-12	. . PIN		1	1
-12	AN960-4	. . WASHER		1	1
-13	22-98519-47	. . BELLCRANK, -V70203P		1	1
-14	22-98519-29	. . PIN, -V70203P		1	1
-15	AN380-2-1	. . PIN		1	1
-16	MS20392-2-43	. . PIN		1	1
-17	AN960-10L	. . WASHER		1	1
-18	31-98519-11	. . SLEEVE, VERTICAL AND SWIVEL CONTROL RIVETED -V70203P		1	1
-19	31-98519-7	. . PLATE ASSEMBLY, VERTICAL AND SWIVEL CONTROL -V70203P		1	1
-20	31-98519-13	. . RING, -V70203P		1	1
-21	31-98508-1	. POST ASSEMBLY, CENTER -V70203P		1	1
-22	31-98510-1	. FAIRING ASSEMBLY, BASE STIFFENER RIVETED -V70203P		1	1
	31-98510-2	. FAIRING ASSEMBLY, BASE STIFFENER RIVETED -V70203P		1	1
-23	31-98529-1	. SPIDER ASSEMBLY, BASE -V70203P		1	1

VHF ANTENNA - FLUSH TYPE
(Conveir Part No. 22-30513)

ATA NO. 23-2-5

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22-1, 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-3, 22(M)-21-4, 22(M)-22, 30-5, 30-6, and 30-8 Dec. 29/61

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23-2-5	3	Dec. 29/61	A-3
23-2-5	4	Dec. 29/61	A-3
23-2-5	5	Dec. 29/61	A-3
23-2-5	6	Dec. 29/61	A-3
23-2-5	IPC 1	Dec. 29/61	A-3
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Chapter 23

VHF ANTENNA - FLUSH TYPE
(Convair Part No. 22-30513)

1. Description and Operation

A. Physical Description.

The flush-type VHF antenna, Convair Part Number 22-30513, is a vertically polarized, top-loaded ground-plane antenna which flush-mounts on the upper side of the airplane fuselage. The antenna is a component of the communications system.

B. Leading Particulars.

Length (approx)	11.75 inches
Width (approx)	11.75 inches
Height (approx)	4.5 inches
Power at operating frequencies	40.0 watts
Voltage standing wave ratio at operating frequencies	2:1

C. Operation.

The flush antenna reflects rf energy over the vhf range from 118 mc to 136.5 mc.

2. Disassembly

A. Complete disassembly of the antenna is not intended or practical. The antenna may be disassembled sufficiently to inspect and repair the electrical connections between the connector and the antenna circuit disc assemblies, and to replace antenna circuit disc assemblies.

CAUTION: DO NOT DEVIATE FROM DISASSEMBLY INSTRUCTION. DEVIATIONS MAY LEAD TO IRREPARABLE DAMAGE TO ANTENNA. DO NOT PROCEED FURTHER THAN NECESSARY WITH DISASSEMBLY TO ACCOMPLISH DESIRED REPAIR, INSPECTION, OR REPLACEMENT.

(1) (See IPC Figure 1.) Remove 13 AN470AD4-4 rivets which attach cover (4) to antenna assembly (7).

(2) Remove three screws (5) from cover (4) and remove cover.

(3) Remove resin from perimeter of matching circuit disc (6) using small knife blade as a scraper.

(4) Remove matching circuit disc (6) from antenna assembly (7).

(5) Scrape all traces of resin from circuit matching disc (6) and antenna assembly (7) using knife blade.

(6) Remove resin from perimeter of matching circuit disc assembly (18).

(7) Unsolder connection between matching circuit disc assembly (18) and contact assembly (16).

(8) Pull contact assembly (16) out far enough to clear matching circuit disc assembly (18).

(9) Remove four screws (2) and remove antenna cap (1).

(10) Remove peening or staking from conductor (15) where it passes through filler bar (8), using care not to destroy threads in filler bar.

(11) Turn matching circuit disc assembly counterclockwise until conductor (15) is unscrewsed from filler bar (8).

(12) Carefully lift matching circuit disc assembly (18) and conductor (15) from cone assembly (22).

(13) Scrape all traces of resin from matching circuit disc assembly (18) and cone assembly (22).

(14) Unsolder connection between conductor (15) and matching circuit disc assembly (18) and remove conductor from matching circuit disc assembly.

NOTE: Further disassembly of antenna assembly is not considered practical. Cone assembly (22) is spot welded and aluminum brazed together. Spacer assembly (9) is bonded and riveted to cone assembly (22).

3. Cleaning

WARNING: USE DRY CLEANING SOLVENT IN WELL-VENTILATED AREA, AVOID PROLONGED INHALATION OF FUMES. OBSERVE FIRE PRECAUTIONS.

A. Wipe antenna with a clean, lint free cloth dipped in dry cleaning solvent recommended in paragraph 6.B.(1)(C).

CAUTION: DO NOT ALLOW DRY CLEANING SOLVENT TO SOAK ON PARTS BEING CLEANED.

4. Inspection

A. General.

(1) Visually inspect antenna for bonding integrity, dents, cracks, loose rivets, and corrosion.

(2) Check mounting holes for cracks.

(3) Check area around spot welds for cracks.

(4) Check connector for cross-threads, stripped-threads, galling and corrosion.

(5) (See IPC Figure 1.) Check security of soldered connection between contact assembly (16) and matching circuit disc assembly (18), and between matching disc assembly and conductor (15).

(6) Check for loose eyelets (21) in matching circuit disc assembly (18).

5. Repair

A. Remove corrosion with aluminum oxide paper recommended in paragraph 6.B.(1)(e).

B. Solder loose connections with solder recommended in paragraph 6.B. (1)(d).

C. (See IPC Figure 1.) Tighten or replace loose eyelets and file flush, taking care not to cut into antenna element surface.

CAUTION: ORIGINAL DIMENSIONS OF ANTENNA MUST NOT BE ALTERED WHEN MAKING REPAIRS.

6. Assembly

A. Antenna Assembly.

(1) (See IPC Figure 1.) Install spacer assembly (9) on cone assembly (22) so that recess for filler bar (8) is parallel to cap (1). Bond with resin recommended in paragraph 6.B.(1)(a) and attach with four rivets (10), using procedure in paragraph 6.B.(2).

(2) Press insert (14) into cone assembly (22) sleeve.

(3) Press insert (13) into place in spacer assembly (9).

(4) Place filler bar (8) into position in spacer assembly (9) recess.

(5) Insert conductor (15) through center hole in matching circuit disc assembly (18) so that head on conductor is in contact with center contact of matching circuit disc assembly.

(6) Place conductor (15), with matching circuit disc assembly (18) in position, in cone assembly (22). Screw conductor into filler bar until shoulder on conductor bottoms on filler bar (8). Line-up contact point on matching circuit disc assembly with contact assembly (16), and holes in matching circuit disc assembly with plate nuts in cone assembly.

(7) Peen-over or stake top of conductor (15).

(8) Push contact assembly (16) in, to make contact with matching circuit disc assembly (18).

(9) Solder contact assembly (16) to outside contact point of matching circuit disc assembly (18) using solder recommended in paragraph 6.B.(1)(d).

(10) Solder conductor head (15) to center of matching circuit disc assembly (18) element using solder recommended in paragraph 6.B. (1)(d).

(11) Install matching circuit disc (6) in cone assembly (22) with insulation side against matching circuit disc assembly (18), attaching with three screws (5).

(12) Fill cavity around edges of two matching circuit discs with resin recommended in paragraph 6.B.(1)(b), using care to obtain a complete seal between matching circuit disc (6) and cone assembly (22). Fill cavity to level of exterior surface of circuit matching disc (6).

(13) Remove three screws (5) and install cover (4), attaching with three screws (5).

(14) Rivet cover (4) to cone assembly (22).

(15) Install cap (1) with inserts (11) projecting through holes in cap. Attach cap with four screws (2). Insure that full contact is made between cap (1) and filler bar (8).

B. Materials and Methods.

(1) Use following materials or equivalents:

	MATERIAL	IDENTIFICATION	SOURCE
(a)	Bonding resin	No. 3135	Narmco Inc. Costa Mesa, California
(b)	Fill resin	No. 777	Coast Proseal & Mfg. Co. Los Angeles, California or Churchill Chemical Co. Los Angeles, California
(c)	Dry cleaning solvent	Federal Spec. P-S-661	Optional
(d)	Solder	Federal Spec. QQ-S571- Comp. SN 60	Optional

	MATERIAL	IDENTIFICATION	SOURCE
(e)	300 grit aluminum oxide paper	Federal Spec. P-C-451	Optional
(f)	320 grit garnet paper	Commercial	Optional
(g)	Naphtha	Federal Spec. TT-N-95	Optional
(h)	Methyl-Ethyl-Ketone	Federal Spec. TT-M-261	Optional
(i)	Sodium dichromate-Sulphuric acid solution		Forest Products Lab. Madison, Wisconsin

(2) Use bonding resin recommended in paragraph 6.B.(1)(a) as follows:

(a) Sand faying surfaces of parts with garnet paper recommended in paragraph 6.B.(1)(f). Clean, first with methyl-ethyl-ketone recommended in paragraph 6.B.(1)(h), and then with naphtha recommended in paragraph 6.B.(1)(g).

(b) Etch faying surface of metallic part with sodium dichromate-sulphuric acid solution recommended in paragraph 6.B.(1)(i).

(c) Apply single coat of binding resin recommended in paragraph 6.B.(1)(a) to one of faying surfaces.

(d) Place faying surfaces together and evenly apply one psi load at joint. Drill, and install rivets.

(e) Cure at 180 to 200 degrees F for minimum of four hours.

7. Fits and Clearances

Not applicable.

8. Testing

A. General.

The antenna should be tested while installed in the airplane, as described in CONVAIR Maintenance Manual Chapter 23-2-0, VHF Communications System, or in an environment which simulates the airplane installation.

9. Trouble Shooting

Not applicable.

10. Storage Instructions

A. Store antenna in either a crushproof cardboard carton or in a wooden crate. Store only one component in each container to prevent excess weight from deforming the component. The container need not be dust-proof providing antenna is carefully wiped with a clean, lint-free cloth moistened with dry cleaning solvent recommended in paragraph 6.B.(1)(c), just prior to use.

CAUTION: DO NOT STORE COMPONENTS NEAR SOURCES OF HEAT.

11. Special Tools, Fixtures and Equipment

Not applicable.

ILLUSTRATED PARTS BREAKDOWN

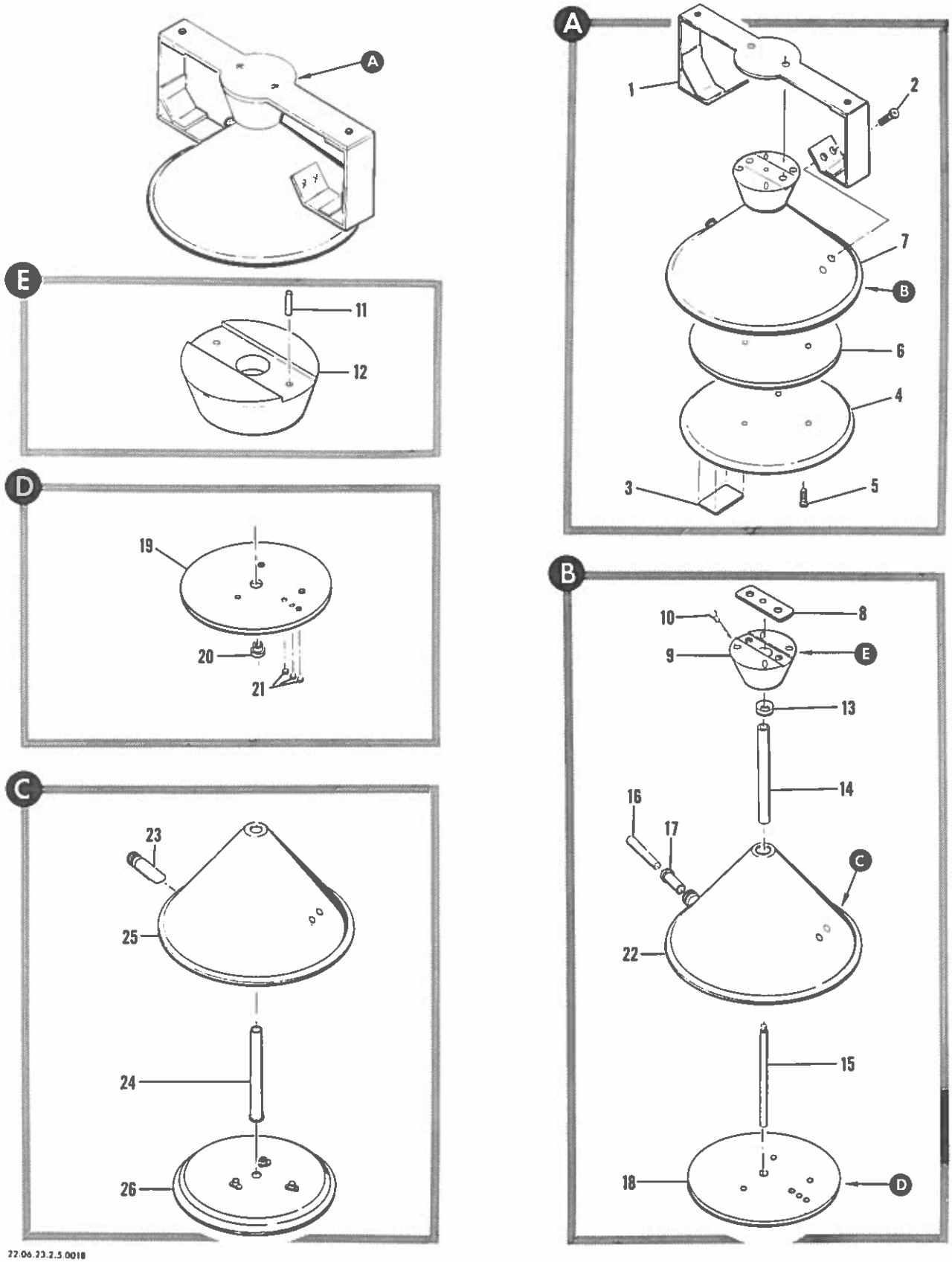
VHF ANTENNA - FLUSH TYPE
(Convair Part No. 22-30513)

ATA NO. 23-2-5

Applicable to Mode 22-1, 22-2, 22(M)-3, 22(M)-4, 22(M)-21-1, 22(M)-21-2, 22(M)-21-3, 22(M)-21-4, 22(M)-22, 30-5, 30-6 and 30-8 Dec. 29/61

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	FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
R	1	22-30513	ANTENNA ASSEMBLY, VHF COMMUNICATION FLUSH TYPE		1		REF
	- 1	22-30505	. CAP, VHF, ANTENNA		1		1
			ATTACHING PARTS				
	- 2	NAS623-3-1	. SCREW		1		4
			----X----				
	- 3	22-30521	. NAMEPLATE		1		1
	- 4	22-30512	. COVER		1		1
			ATTACHING PARTS				
	- 5	AN515-6R10	. SCREW		1		3
			----X----				
R	- 6	22-30517-11	. DISC, MATCHING CIRCUIT		1		1
R	- 7	22-30513-13	. ANTENNA ASSEMBLY, VHF COMMUNICATION		1		1
	- 8	22-30507	. . BAR, FILLER		1		1
R	- 9	22-30515	. . SPACER ASSEMBLY, VHF ANTENNA		1		1
			ATTACHING PARTS				
R	- 10	P200-5	. . RIVET, CONVAIR 97-63004-203 -V98524-		1		4
			----X----				
R	- 11	3591-3CNX380	. . . INSERT, CONVAIR 95-03003-006 -V91767-		1		1
	- 12	22-30515-7	. . . SPACER, BLOCK		1		1
	- 13	22-30509-7	. . INSERT, TEFLON		1		1
	- 14	22-30509-13	. . INSERT, TEFLON		1		1
	- 15	22-30513-7	. . CONDUCTOR		1		1
R	- 16	22-30518	. . CONTACT ASSEMBLY, VHF ANTENNA SOLDERED		1		1
	- 17	22-30509-9	. . INSERT, TEFLON		1		1
	- 18	22-30517-1	. . DISC ASSEMBLY, MATCHING CIRCUIT		1		1
R	- 19	22-30517-7	. . . DISC		1		1
R	- 20	SE67	. . . EYELET, CONVAIR 93-58005-004 -V61957-		1		1
R	- 21	SE27	. . . EYELET, CONVAIR 93-58005-003 -V61957-		1		3
R	- 22	22-30513-11	. . CONE ASSEMBLY, VHF ANTENNA		1		1
R	- 23	22-30506-7	. . . CONNECTOR		1		1
R	- 24	22-30508-7	. . . SLEEVE		1		1
R	- 25	22-30510	. . . CONE ASSEMBLY, RIVETED		1		1
R	- 26	22-30511	. . . PAN ASSEMBLY, RIVETED		1		1

CLUB COMPARTMENT SEAT ASSEMBLIES - TWIN

(Convair Part Nos. 22-93597-807, -813, -815, -823, -825 and -827)

ATA NO. 25-2-12

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22(M)-3, 22(M)-21-1, 22(M)-21-2, 22(M)-21-4, and 30-5

Sep. 25/62

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Chapter 25

CLUB COMPARTMENT SEAT ASSEMBLIES - TWIN
(Convair Part Nos. 22-93597-807, -813, -815, -823, -825 and -827)

1. Description

A. General.

(1) The Club Compartment Seat Assemblies - Twin, Convair Part Numbers 22-93597-807, -813, -815, -823, -825 and -827, are manufactured by the Hardman Tool and Engineering Corporation, Los Angeles, California.

(2) The club compartment seat assembly - twin, is a nonadjustable, fiberglass molded unit, upholstered with plastic foam and naugahyde. The assembly consists of two individual seats with armrests. A center armrest separates the two seats. Each seat is equipped with an ash tray and seat belt attachments. Provisions for holding food trays are located in the forward end of the seat armrests. Molded legs support each seat. The lower portion of each leg is upholstered with naugahyde and a strip of fiberglass molding.

(3) Removable seat and backrest cushions are installed in each seat. Velcro, an inter-meshing hook and pile type fiber strip (tape), is attached to the forward, lower side of the seat cushion and on the aft top and sides of the backrest cushion. Mating Velcro strips, attached to the seat structure, hold the cushions in their respective locations. Two button-snap fasteners on the top aft side of the back cushion, anchor the top of the cushion to the seat structure. Velcro strips on the inboard ends of both cushion covers, provide access to the foam rubber pads inside the cushion.

(4) Four button-snap fasteners, located on the underside of each seat bottom, are utilized for attachment of a plyable, vinyl-coated, nylon-fabric life vest container.

(5) Four quick-release type pins, two in each seat leg, attach the seat assembly to the airplane structure. A rubber retainer secures the release pins to the seat legs.

B. Leading Particulars.

Weight.....50 pounds

Overall Dimensions:

Height.....34 inches

Length.....55 inches

Width.....24 inches

2. Disassembly

A. (See IPC Figure 1.) The two seat shells are constructed from molded fiberglass and cannot be disassembled. Remove detachable components as follows:

(1) Remove seat cushion assemblies (41) from inner shell.

NOTE: The forward underside of seat cushions are attached to inner shell with strips of Velcro; pull to separate.

(2) Open the aft side of cover (43) by separating flaps sealed with Velcro strips and remove cushion (42).

(3) Remove cover (44) from cushion (42).

(4) Unsnap two fasteners attaching top of seat-back cushion assemblies (45) to inner shell (62); remove two cushion assemblies.

NOTE: The aft top and sides of cushion assemblies are attached to inner shell with strips of Velcro; pull to separate.

(5) Open the bottom end of cover (48) by separating flaps sealed with Velcro strips and remove cushion.

(6) Remove cover from cushion.

(7) Remove stitching from flaps (49) and (50); remove pads (51) and stiffeners (52).

(8) Remove eyelets (53) and sockets (54) from cover (48).

(9) Unscrew nut (31) and remove bolt (30) from bolt (29).

(10) Unscrew nut (28) from bolt (29) and remove bolt (29), tube (34) and washer (27) from inner shell.

(11) Unsnap four fasteners and remove life vest containers (18) from under side of outer seat shells (63).

(12) Remove fasteners (19) and (20) from outer shells.

(13) Remove fasteners from seat back inner shell.

(14) Remove two screws (4) and washers (5).

(15) Remove pins (2) and retainers (3) from leg assemblies.

(16) Remove ash tray as follows:

(a) Slide lid (64) to open position.

(b) Remove cup assembly (67).

(c) Remove screw (69) from rim (68) and screw (71) from bottom of housing assembly (70).

(d) Close lid (64) and remove housing assembly (70) with rim (68) and lid (64) attached.

(e) Separate rim (68), lid (64) and housing assembly (70).

(f) Remove knob (65) from lid (64) by removing two screws (66).

3. Cleaning

A. Wipe all painted metal parts with a clean, lint-free cloth moistened with cleaning solvent recommended in paragraph 6.B.(1). Unpainted metal parts may be submerged in cleaning solvent and scrubbed as necessary. Dry all parts thoroughly with filtered, moisture-free air and a clean, lint-free cloth.

WARNING: USE SOLVENT IN A WELL VENTILATED AREA. AVOID PROLONGED INHALATION OF SOLVENT FUMES. KEEP SOLVENT AWAY FROM OPEN FLAME.

B. Clean seat shells, seat cushion cover, back cushion cover, seat upholstery and covering on lower portion of legs with a cloth dampened in a soap and water solution. Use soap recommended in paragraph 6.B.(10). Wipe surface clean with a cloth dampened in cold water and dry thoroughly with a clean, lint-free cloth. To clean heavily soiled areas, use cloth moistened with solvent recommended in paragrapy 6.B.(4).

C. Cushions and cloth covers may be washed in a mild soap and water solution. Use soap recommended in paragraph 6.B.(10). Rinse in cold water, squeeze gently and air dry thoroughly.

D. Adhesive cement deposits may be removed by light applications of solvent recommended in paragraph 6.B.(3).

CAUTION: EXCESSIVE APPLICATION OF SOLVENTS CAN DAMAGE LEATHER OR SYNTHETIC MATERIALS.

4. Inspection

A. General.

(1) Under a strong light, preferably under magnification, inspect all parts, as applicable, for nicks, cracks, cuts, dents, scratches, corrosion, crossed or stripped threads, chafing, scoring or excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of a part.

(2) Replace all parts that fail to meet inspection requirements.

(3) Where doubt exists, concerning the serviceability of standard AN, NAS, NAF or MS parts renew the part.

B. Special Component Inspection.

Accomplish a Magnetic Particle Inspection, in accordance with specification MIL-I-6868, on bolt (29).

5. Repair

A. Remove minor nicks and scratches from aluminum alloy parts by polishing with material recommended in paragraph 6.B.(11).

B. Remove minor nicks and scratches from steel parts by polishing with material recommended in paragraph 6.B.(12).

CAUTION: EXCESSIVE USE OF ABRASIVES CAN DAMAGE PLATED SURFACES.

C. Repaint seat shells as follows:

(1) Prime bare surfaces with primer recommended in paragraph 6.B.(18).

(2) Coat primer with paint recommended in paragraph 6.B.(21) or 6.B.(22), as applicable.

(3) Finish surface with enamel recommended in paragraph 6.B.(19) or 6.B.(20), as applicable.

NOTE: Do not paint surfaces where adhesive cement will be applied.

D. Replace damaged areas of seat and leg upholstery as follows:

(1) Remove upholstery by peeling; use a thin knife to aid in separation from seat shells or leg assemblies.

(2) Remove adhesive cement from seat shells by softening with material recommended in paragraph 6.B.(3). Scrape off adhesive with a metal blade.

(3) Wipe surface clean using a cloth dampened with material recommended in paragraph 6.B.(4).

(4) Cement upholstery, as specified in paragraphs 6.B.(25) to seat shells with material recommended in paragraph 6.B.(14); apply per Specification CVA-6-99, Type I.

(5) Sew molding, specified in paragraph 6.B.(24), to seat leg covers, specified in paragraph 6.B.(23). Cement covers to leg assemblies with material recommended in paragraph 6.B.(14); apply per Specification CVA-6-99, Type I.

(6) (See IPC Figure 1.) Position stiffeners (52) and pads (51) in flaps (49) and (50) and sew seams of flaps.

(7) Replace or repair cushion covers with leather specified in paragraph 6.B.(26) thru 6.B.(29), as applicable.

E. Replace Velcro fiber strips, specified in paragraph 6.B.(17), as follows:

(1) Fiber strips are sewn to covers (48) and (52). If repair or replacement is necessary, attach strips by sewing.

(2) Fiber strips are attached to inner shells (71) with cement recommended in paragraph 6.B.(13). To remove, soften cement with material recommended in paragraph 6.B.(3).

F. Repair molded fiberglass as follows:

(1) Minor repairs of fiberglass surfaces consist of filling in the damaged area with a mixture of catalyzed resin and chopped glass fibers; or laying in several layers of catalyzed resin-impregnated glass cloth. Wide abrasions will generally require patching with sections of glass cloth, while narrow scratches or gouges may be loaded with a thick mixture of chopped glass fibers and resin.

(a) Remove rough edges of scratch or abrasion by hand sanding with number 40 to 60 abrasive grit.

WARNING: AVOID INHALATION OF FUMES AND DIRECT CONTACT WITH TOLUENE REFERENCED IN PARAGRAPH (b). TOLUENE AND FUMES RELEASED ARE TOXIC AND HIGHLY EXPLOSIVE. KEEP TOLUENE AWAY FROM OPEN FLAME.

(b) Remove abrasive particles and dirt from repair area with a cloth moistened with toluene listed in paragraph 6.B.(2).

(c) Damaged fiberglass areas may be filled with catalyzed resin. The required quantity of catalyzed resin can be prepared by thoroughly mixing the weights of resin and catalyst as indicated in either of the following:

Mix 100 parts resin with 25 parts catalyst as listed in paragraph 6.B.(5), (7), and (8).

WARNING: LEAVE CONTAINER OPEN AT ALL TIMES TO PREVENT POSSIBLE MILD EXPLOSION DUE TO GAS FORMATION.

Mix 100 parts resin with 10 parts catalyst as listed in paragraph 6.B.(6), and (8).

NOTE: For narrow scratches or gouges, accomplish step (d). For wide abrasions, accomplish step (e).

(d) Prepare a thick paste of catalyzed resin mixed with glass fibers chopped from glass cloth. Work paste into scratch or gouge with flat blade or spatula until repair is slightly higher than surrounding area.

(e) Carefully sand surface in a roughly circular area around the abrasion to produce a neatly feathered or tapered edge.

CAUTION: DO NOT SAND BELOW THREE LAYERS OF FIBERGLASS LAMINATE.

(f) Taper edge about 0.50 inch wide around damage. Cut filler patches from a section of clean number 181 glass cloth, listed in paragraph 6.B.(9). Cut patches large enough to overlap edges of sanded area. Brush damaged section and one filler patch with catalyzed resin. Apply this patch to damaged section, brushing out air bubbles and excess resin. Continue laying on resin-impregnated filler patches until repair is built up slightly above surface of surrounding area. With a cloth moistened in toluene, observing warning in step (a), remove excess resin which may have worked out around edges of repair.

(g) Cure repair at 150 to 200 degress F from two to four hours, using portable infrared heat lamps or heating pads.

(h) After curing, remove excess material, then smooth surface of repair by hand sanding to proper contour with number 80 to 120 abrasive grit.

(i) Mix a small amount of resin with catalyst as specified in step (c), then brush mixture thinly over entire area of repair, overlapping repair about 0.5-inch. Allow to dry at room temperature. Do not sand after cure is completed.

6. Assembly

A. (See IPC Figure 1.) Assemble as follows:

(1) Place bolt (30) in clevis holes on end of bolt (29) and install nut (31).

(2) Position tube (34) and washer (27) on end of bolt (29); insert the threaded end of bolt (29) through plate (33), seat shells and washer.

(3) Attach bolt (29) to seat shells with nut (28).

(4) Attach fasteners (19) and (20) to the under side of outer seat shells, then attach life vest containers (18) with snap fasteners.

(5) Attach retainers (3) to leg assemblies with washers (5) and screws (4).

(6) Install pins (2) in legs and attach pin ends to retainer (3).

(7) Attach fasteners to seat back inner shells.

(8) Install cover over cushion and position the covered cushion inside seat cover.

(9) Seal the aft side of seat cover by pressing flaps together; ensure that Velcro strips are aligned.

(10) Install two eyelets (53) and sockets (54) in seat back cover (48).

(11) Install cover over cushion and position the covered cushion inside seat-back cover.

(12) Seal the bottom end of seat-back cover (52) by pressing flaps together; ensure that Velcro strips are aligned.

(13) Attach the top of seat-back cushion to inner shells with fasteners.

(14) Align Velcro stripping on aft top and sides of seat-back cushion assemblies and inner shells; press cushions against inner shells.

(15) Align Velcro stripping on the forward, underside of seat cushion assemblies and inner shells. Press seat cushions into inner shells and fit aft corners into flaps.

(16) Install ash tray as follows:

(a) Attach knob (65) to lid (64) with two screws (66).

(b) Place lid and rim (68) on housing assembly (70) and position components in well of armrest.

(c) Open lid, then attach housing assembly (70) with screw (71) and rim (68) with screw (69).

(d) Press cup assembly (67) into housing assembly (70) and close lid.

B. Materials.

Use materials listed, or equivalent.

NOTE: For explanation of USAGE CODE listed herein, refer to IPC section.

MATERIAL	IDENTIFICATION	SOURCE
(1) Cleaning Solvent	Federal Specification P-S-661	Optional
(2) Thinner Toluene	Federal Specification TT-T-548	Optional
(3) Solvent, Methyl Ethyl Ketone	Federal Specification TT-M-261	Optional
(4) Naphtha Aliphatic	Federal Specification TT-N-95	Optional
(5) Catalyst	Curing Agent T-1	Shell Chemical Corp. New York 20, New York
(6) Catalyst	Hardener 951	Furane Plastics, Inc. 4516 Brazil St. Los Angeles 39, California
(7) Resin	Epon 815	Shell Chemical Corp. New York 20, New York
(8) Resin	Epon 828	Shell Chemical Corp. New York 20, New York
(9) No. 181 Glass Cloth	Federal Specification MIL-F-9084	Optional
(10) Soap, Cleaning	Castile	Optional
(11) Aluminum Oxide Abrasive Cloth	Federal Specification P-C-451	Optional
(12) Crocus Abrasive Cloth	Federal Specification P-C-458	Optional
(13) Cement	EC826 CEM76	Minnesota Mining & Mfg. Co. St. Paul, Minnesota
(14) Cement	EC847 CEM30-10	Minnesota Mining & Mfg. Co. St. Paul, Minnesota

MATERIAL	IDENTIFICATION	SOURCE
(15) Cement	3130 A & B (Equal parts of Metalbond 3130A & 3130B) CEM 105	Narmco Resins & Coating Co. Costa Mesa, California
(16) Wrapping Paper	Federal Specification UU-P-271	Optional
(17) Fiber Strips (a) Hook	Velcro Tape HWL-V200-1-100	Hartwell Corporation 9035 Venice Boulevard Los Angeles 34, California
(b) Pile	HWL-V200-1-200	Hartwell Corporation 9035 Venice Boulevard Los Angeles 34, California
(18) Paint	Primer #24 Synflex Primer #968	Andrew Brown Paint Co. Los Angeles, California
(19) Paint	Vinyl Phenolic Snowshoe White #169-W-516 (Applicable to Code B Airplanes)	W. P. Fuller Paint Co. Los Angeles, California
(20) Paint	Vinyl Phenolic Pearl White #169-W-515 (Applicable to Code A and C Airplanes)	W. P. Fuller Paint Co. Los Angeles, California
(21) Paint	Textured Vinyl LA8023L+639 Showshoe White #CC 1308 (Applicable to Code B Airplanes)	Andrew Brown Paint Co. Los Angeles, California
(22) Paint	Textured Vinyl LA9129+L639 Pearl White #CC 1368 (Applicable to Code A and C Airplanes)	Andrew Brown Paint Co. Los Angeles, California
(23) Cover, Seat Leg	Naugahyde, Grade 15210A Color Charcoal, Midas MS-12	U. S. Rubber Company Los Angeles, California

MATERIAL	IDENTIFICATION	SOURCE
(24) Molding Seat Leg	Fiberglass, Mylar Coated, Color Gold Pattern #65, Style H-29/LAM 233-200	Duracoate Corporation Ravenna, Ohio
(25) Upholstery	Naugahyde, 18 oz. Color GA112, Antique White, CC1415	U. S. Rubber Company Los Angeles, California
(26) Cover, Cushion	Leather, Haircell Gran, Color BD863-A Showshoe White, CC1308 (Applicable to Code B Airplanes)	Garden State Tanning Company, Incorporated New York, New York
(27) Cover	Leather, Crush Grain, Color BE695BJ, Inca Gold, CC1397 (Applicable to Code A and C Airplanes)	Garden State Tanning Company, Incorporated New York, New York
(28) Cover, Cushion	Leather, Crush Grain, Color BE1132J, Cable Blue, CC1398 (Applicable to Code A and B Airplanes)	Garden State Tanning Company, Incorporated New York, New York
(29) Cover, Cushion	Leather, Antique Grain Color BA600A, Tunis Blue, CC1474 (Applicable to Code C Airplanes)	Garden State Tanning Company, Incorporated New York, New York
(30) Cover, Cushion	Fabric Nylon Rib Color 2038-1 Vermillion, CC1320 Moss Rose #70010 (Applicable to Code D Airplanes)	E. F. Timme & Son. Inc. One Park Avenue New York 16, New York

7. Fits and Clearances

Not applicable.

8. Testing

Not applicable.

9. Trouble Shooting

Not applicable.

10. Storage Instructions

A. Wrap the seat assembly in paper, recommended in paragraph 6.B.(16), and seal with tape. Stamp seat assembly part number and date of overhaul on a tag and attach, in a convenient location, on seat wrapper.

B. Store the seat assembly in a cool, dry area, maintain room temperature at 68 to 72 degrees F. Keep away from sunlight and heat sources.

11. Special Tools, Fixtures and Equipment

Not applicable.

ILLUSTRATED PARTS BREAKDOWN

CLUB COMPARTMENT SEAT ASSEMBLIES - TWIN

(Convair Part Nos. 22-93597-807, -813, -815, -823, -825 and -827)

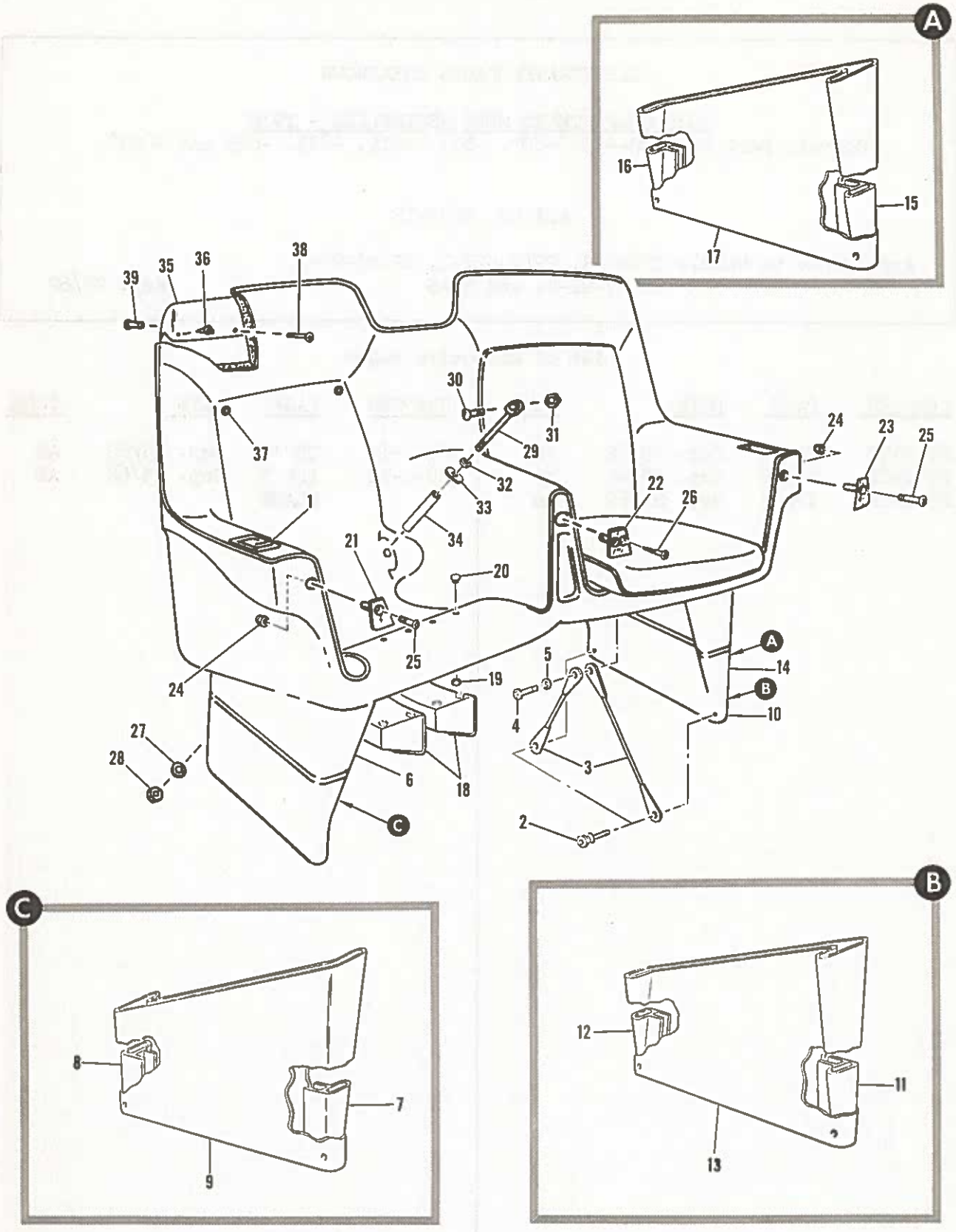
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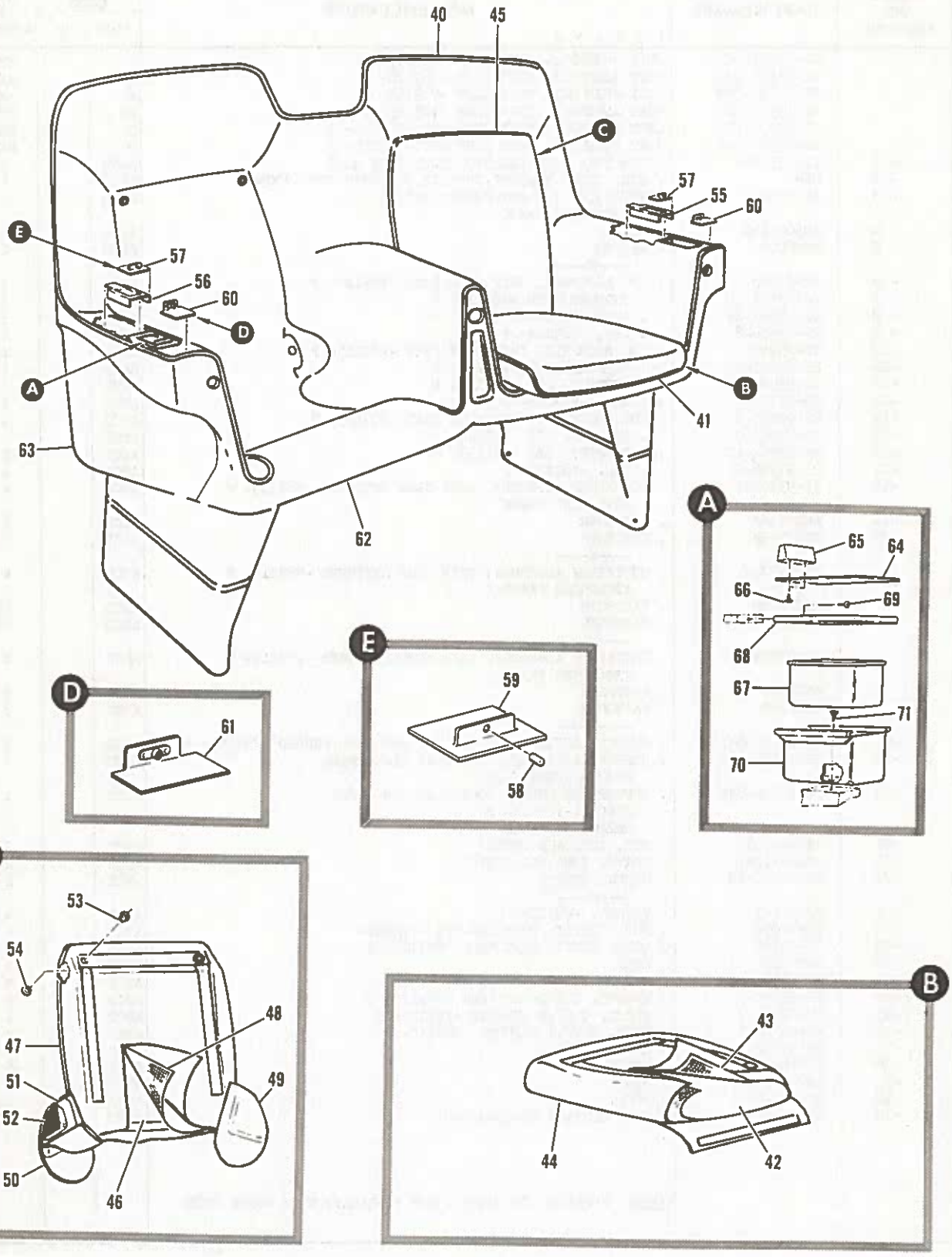
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25-2-12	IPC 2	Sep. 25/62	AB
25-2-12	IPC 3	Sep. 25/62	AB
25-2-12	IPC 4	Sep. 25/62	AB
25-2-12	IPC 5	Sep. 25/62	AB
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22.04.25.03.011.1

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1	22-93597-807	SEAT ASSEMBLY, TWIN CLUB -V83115- P	A		REF
	22-93597-823	SEAT ASSEMBLY, TWIN CLUB -V83115- P	ABC		REF
	22-93597-825	SEAT ASSEMBLY, TWIN CLUB -V83115- P	A		REF
	22-93597-827	SEAT ASSEMBLY, TWIN CLUB -V83115- P	BC		REF
	22-93597-815	SEAT ASSEMBLY, TWIN CLUB FWD -V83115- P	D		REF
	22-93597-813	SEAT ASSEMBLY, TWIN CLUB AFT -V83115- P	D		REF
- 1	22-93570-5	. ASH TRAY INSTALLATION, TWIN CLUB SEAT	ABCD		2
- 2	2648	. PIN, QUICK RELEASE CONVAIR 96-78810-010 -V00502-	ABCD		4
- 3	22-93565	. RETAINER, PIN ATTACHMENT -V83115- P	ABCD		4
		ATTACHING PARTS			
- 4	AN504C4-8	. SCREW	ABCD		2
- 5	AN960C4	. WASHER	ABCD		2
		----X----			
- 6	22-93556-1	. LEG ASSEMBLY, TWIN CLUB SEAT -V83115- P	ABCD		1
- 7	22-93561-10	. . SUPPORT, LEG -V83115- P	ABCD		1
- 8	22-93561-14	. . SUPPORT, LEG -V83115- P	ABCD		1
- 9	22-93556-8	. . LEG, -V83115- P	ABCD		1
-10	22-93556	. LEG ASSEMBLY, TWIN CLUB SEAT -V83115- P	ABCD		1
-11	22-93561-9	. . SUPPORT, LEG -V83115- P	ABCD		1
-12	22-93561-13	. . SUPPORT, LEG -V83115- P	ABCD		1
-13	22-93556-7	. . LEG, -V83115- P	ABCD		1
-14	22-93556-3	. LEG ASSEMBLY, TWIN CLUB SEAT -V83115- P	ABCD		1
-15	22-93561-9	. . SUPPORT, LEG -V83115- P	ABCD		1
-16	22-93561-17	. . SUPPORT, LEG -V83115- P	ABCD		1
-17	22-93556-9	. . LEG, -V83115- P	ABCD		1
-18	31-93302-1	. CONTAINER ASSEMBLY, LIFE VEST STITCHED -V83115- P	ABCD		2
		ATTACHING PARTS			
-19	AN227-8B	. FASTENER	ABCD		8
-20	AN227-9B	. FASTENER	ABCD		8
		----X----			
	31-93302-1	. CONTAINER ASSEMBLY, LIFE VEST STITCHED -V83115- P	ABCD		4
		ATTACHING PARTS			
	AN227-8B	. FASTENER	ABCD		16
	AN227-9B	. FASTENER	ABCD		16
		----X----			
	31-93302-1	. CONTAINER ASSEMBLY, LIFE VEST STITCHED -V83115- P	ABCD		2
		ATTACHING PARTS			
	AN227-8	. FASTENER	ABCD		8
	AN227-9	. FASTENER	ABCD		8
		----X----			
-21	22-93596-841	. SUPPORT ASSEMBLY, FOOD TRAY ARM INBD BONDED -V83115- P	ABCD		1
-22	22-93596-837	. SUPPORT ASSEMBLY, FOOD TRAY ARM CENTER	ABCD		1
		BONDED -V83115- P			
-23	22-93596-839	. SUPPORT ASSEMBLY, FOOD TRAY ARM OUTBD	ABCD		1
		BONDED -V83115- P			
		ATTACHING PARTS			
-24	AN364-1032	. NUT, INBD AND OUTBD	ABCD		2
-25	AN520-10R7	. SCREW, INBD AND OUTBD	ABCD		2
-26	AN545-10-10	. SCREW, CENTER	ABCD		2
		----X----			
-27	22-93563	. WASHER, -V83115- P	ABCD		4
-28	22K1-054	. NUT, CONVAIR 96-37568-011 -V72962-	ABCD		4
-29	22-93567	. BOLT, CLEVIS SEAT BELT -V83115- P	ABCD		4
-30	AN24-12A	. BOLT	ABCD		4
-31	MS20364-428	. NUT	ABCD		4
-32	22-93566-7	. WASHER, CLEVIS SUPPORT -V83115- P	ABCD		4
-33	22-93562-7	. PLATE, CLEVIS SUPPORT -V83115- P	ABCD		4
-34	22-93564-7	. TUBE, CLEVIS SUPPORT -V83115- P	ABCD		4
-35	22-93662	. CAP -V83115- P	ABCD		2
-36	AN545-8-4	. SCREW	ABCD		8
-37	AN227-10B76	. STUD	ABCD		4
-38	NAS220-8	. SCREW	ABCD		10
-39	Q3113-8-20	. NUT, CONVAIR 96-38001-003	ABCD		10

NOTE: REFER TO IPC PAGE 4 FOR EXPLANATION OF USAGE CODE



22 04 25 05 011 2 B

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1 -40	22-93584-1	. UPHOLSTERY, -V83115- P	ABCD		AR
-41	22-93569	. CUSHION ASSEMBLY, CLUB SEAT -V83115- P	ABCD		2
	22-93569-3	. CUSHION ASSEMBLY, CLUB SEAT -V83115- P	D		2
-42	22-93569-11	. . CUSHION, SEAT -V83115- P	ABC		1
	22-93569-7	. . CUSHION, SEAT -V83115- P	D		1
-43	22-93569-19	. . COVER, SEAT -V83115- P	ABCD		1
	22-93569-17	. . COVER, SEAT -V83115- P	D		1
-44	22-93569-27	. . COVER, -V83115- P	ABCD		1
	311228	. . HOOK, -V83115- P	ABCD		AR
	311229	. . PILE, -V83115- P	ABCD		AR
-45	22-93569-1	. CUSHION ASSEMBLY, CLUB SEAT BACK -V83115- P	ABCD		2
	22-93569-5	. CUSHION ASSEMBLY, CLUB SEAT BACK -V83115- P	D		2
-46	22-93569-13	. . CUSHION, BACK -V83115- P	ABCD		1
	22-93569-9	. . CUSHION, BACK -V83115- P	D		1
-47	22-93569-15	. . COVER, BACK CUSHION -V83115- P	ABCD		1
-48	22-93569-29	. . COVER, -V83115- P	ABCD		1
-49	22-93569-20	. . FLAP, -V83115- P	ABCD		1
-50	22-93569-21	. . FLAP, -V83115- P	ABCD		1
-51	22-93569-23	. . PAD, -V83115- P	ABCD		2
-52	22-93569-25	. . STIFFENER, -V83115- P	ABCD		2
-53	550A	. . EYELET, -V83115- P	ABCD		2
-54	C548	. . SOCKET, -V83115- P	ABCD		2
	311228	. . HOOK, -V83115- P	ABCD		AR
	311229	. . PILE, -V83115- P	ABCD		AR
-55	22-93638-7	. SHELF, CLUB SEAT ASH TRAY LID LH -V83115- P	ABCD		1
-56	22-93638-8	. SHELF, CLUB SEAT ASH TRAY LID RH -V83115- P	ABCD		1
-57	22-93579	. SUPPORT ASSEMBLY, CLUB SEAT TRIM ASH TRAY -V83115- P	ABCD		2
-58	22-93578	. . PIN, CLUB SEAT SUPPORT -V83115- P	ABCD		2
-59	22-93573	. . SUPPORT, -V83115- P	ABCD		2
-60	22-93628	. SUPPORT ASSEMBLY, ASH TRAY -V83115- P	ABCD		2
-61	22-93628-7	. . SUPPORT -V83115- P	ABCD		2
-62	22-93597-7	. SHELL, INNER -V83115- P	ABCD		1
-63	22-93597-9	. SHELL, OUTER -V83115- P	ABCD		1
	22-93597-11	. SHELL, OUTER -V83115- P	ABCD		1
	22-93570-5	. ASH TRAY INSTALLATION, -V83115- P	ABCD		REF
-64	22-93574	. . LID, ASH TRAY -V83115- P	ABCD		1
-65	22-93575	. . KNOB, ASH TRAY LID -V83115- P	ABCD		1
-66	AN507C440-4	. . SCREW	ABCD		4
-67	22-93583	. . CUP ASSEMBLY, ASH TRAY -V83115- P	ABCD		1
-68	22-93576	. . RIM, ASH TRAY -V83115- P	ABCD		1
-69	AN507UB440-3	. . SCREW	ABCD		1
-70	22-93571-1	. . HOUSING ASSEMBLY, ASH TRAY RIVETED	ABCD		1
-71	AN550-5-4	. . . SCREW	ABCD		1

EXPLANATION OF IPC USAGE CODE

CODE	MODEL NO.	CUSTOMER
A = USED ON	22(M)-3-5	CATHAY
B = USED ON	22(M)-21-1 AND -4	VIASA
C = USED ON	22(M)-21-2	ALASKA
D = USED ON	30-5 thru -24	AAL

PASSENGER SEAT ASSEMBLIES - DOUBLE LUXURY

(Convair Part Nos. 22-90490 and 22-93694 Series;
30-94500, 30-94502 and 30-94553 Series)

ATA NO. 25-2-31

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22(M)-3, 22(M)-4,
22(M)-21-3, 22(M)-22,
30-6, and 30-8

July 20/62

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Chapter 25

PASSENGER SEAT ASSEMBLIES

(Convair Part No. 22-90490 Series)
(Convair Part No. 22-93694 Series)
(Convair Part No. 30-94500 Series)
(Convair Part No. 30-94502 Series)
(Convair Part No. 30-94553 Series)

1. Description and Operation

A. Physical Description

(1) The Convair 22-90490, 22-93694, 30-94500, 30-94502 and 30-94553 series, double luxury, passenger seat are primarilly riveted sheet metal structure and consist of the major components of seat base assembly, lock assemblies, leg assembly, side panel and armrest assemblies and food tray assemblies. The seats are mounted as units on two lock fittings at the outboard end at seat cushion level and two floor attach fittings at the base of the single leg.

(2) Each seat provides foam-padded seat bottom and back cushions, foam padded armrests, a pull-out food tray installation in the rear of the seat back, a lever, cable and lock installation for controlling recline and locking of the seat back, safety belt attach fittings and ash trays with sliding or lid-type closures.

(3) Some seats not having passenger accomodations immediately aft contain dummy food trays in the rear of the seat back.

(4) Some seats, applicable on usage code K, N-Q, U, W, AG, AK-AM, AR and AT, contain seat belt energy absorber assemblies.

(5) Some seats, applicable on usage code A, G, K, N, Q, R, S, U, W, X, AD, AG, AK, AM-AP, AR and AT, provide variable positioning passenger footrest assemblies mounted on the aft underside of the seat base frame.

(6) Each functional food tray is provided with a recess at the rear of the seat back. Support arms, pivoted on the seat back pivot pin, carry a plastic tray pivoted on the upper end of the support arms. When not in use the tray is folded into the seat back and latched to a keeper in the seat structure. When the latch is pulled out, the tray folds down and the support arms pivot rearward to make the tray level. Stops on the tray pivot point control the tray angle. Stops on the seat base structure control the limit of the support arm motion.

B. Leading Particulars

Size (tray closed)

Width	52 inches
Height	44 inches
Length	28 inches
Weight (approximate)	57 to 60 pounds
Angle of Recline	45 degrees
Recovery Time	2.0 seconds
Breakover	35 pounds steady pull

C. Operation

(1) The key operating feature of the seat is the reclining back and control. A lever in each side arm rest of each seat is connected by a cable to a seat lock unit installed in the seat base structure.

(2) A breakover mechanism is mounted on the aft end of the seat lock unit, and the longer leg of the seat back engages a slot in the lower end of the breakover mechanism below the seat back pivot point. By this arrangement the seat lock controls movement of the seat back aft of normal. The breakover mechanism limits forward motion of the seat back to a normal forward seating position until a load of over 35 pounds is applied forward.

(3) The seat lock is a self-contained unit mounted under the base assembly. When the lever is lifted, the cable is pulled and the arm at the lock unit is actuated. The seat lock will release for back recline up to a maximum of 45 degrees. When reclined, the built-in spring provides recovery force for returning to normal position upon re-tripping the lever.

2. Disassembly

A. General

(1) The upholstery covers are fastened by Velcro tapes. The fixed section is a tape with small loops or eyes covering the surface; the section sewn to the cover is a tape of short stiff hooked fibers. When the cover section is pressed flat against the fixed section, the short fibers enter the eyes to form many hook-and-eye matings. This fastener is hightly resistant to a pull in the plane of the joint, but separates readily when pulled vertically to the plane.

(2) The seat cushion foam lies loose in the pan and is effectively held by the cushion cover. All other foam is cemented in place and is likely to be damaged beyond use by removal. Remove only for replacement. Handle cemented foam pieces with care to avoid pulling or stressing foam. Refer to paragraph 5.B for procedure to remove or install foam.

B. Seat Cushions (See IPC Figure 1, Sheet 1.)

(1) Remove seat cushion assembly by peeling Velcro from center of cover on front underside of seat base, across front and around cover.

(2) Remove cover (50) and (51) from cushion (52).

(3) Remove pade (53) from base assembly fairing.

(4) Remove sock (54) and pad (55).

C. Seat Back and Food Tray Assembly (See IPC Figure 1, Sheet 1.)

(1) Remove each seat back by removing two pins (7).

(2) At same time remove food tray assembly or dummy food tray fairing (44).

D. Food Tray Assembly (See IPC Figure 1, Sheet 1.) Applicable on Usage Code A, C-E, G-N, P-S, U, W-X, Z-AB, AD-AK, AM-AP and AR, AT.

(1) Remove latch (31) from table assembly (33) by removing three screws (30).

(2) Remove table assembly (33) from support assembly (39) by removing four screws (32).

(3) Remove four screws (40), four bushings (41) and two bushings (42) from support assembly (39).

E. Fairings (See IPC Figure 1, Sheet 1.)

(1) Remove center hinge fairing (61) from the aft side of the seat base assembly (288) by removing two screws (62) and two screws (63).

(2) Remove back fairing (64) from the inboard leg of the inboard seat back by removing four screws (66).

(3) Remove back fairing (65) from the outboard leg of the outboard seat back by removing four screws (66).

F. Footrest Assembly (See IPC Figure 1, Sheet 4.) Applicable on Usage Code A, G, K, N, Q-S, U, W-X, AD, AG, AK, AM-AP, AR and AT.

(1) Applicable on usage code A, R, X, AN. From the aft underside of the seat base assembly (288) remove footrest assembly (220) by removing eight bolts (221) and two bolts (222).

(2) Applicable on usage code G, K, N, Q, S, U, W, AD, AG, AK, AM, AP, AR, AT. From the aft underside of the seat base assembly (288) remove footrest assembly (220) by removing ten bolts.

(3) Disassemble footrest assembly by removing two end brackets (230) and one center bracket (231).

(a) Remove nut (223), washer (224), screw (232), nut (244), washer (245), screw (246), retaining ring (240), pin (241), cotter pin (236), washer (237) and clevis pin (238) from outboard bracket (230).

(b) Remove screw (232), nut (244), washer (245), screw (246), retaining ring (240), pin (241), cotter pin (236), washer (237) and clevis pin (238) from inboard bracket (230).

(c) Remove nut (223), washer (224), screw (233), nut (244), washer (245), screw (247), retaining ring (240), pin (242), cotter pin (236), washer (237) and clevis pin (239) from center bracket (231).

(4) Remove two crossbar assemblies (248) and (249) with lower footrest parts attached from two brackets (230) and one bracket (231) by removing, at the same time, four washers (225), four triplates (226), four bushings (227), four bushings (228), four washers (229), four springs (234), four springs (235) and four pawls (243).

(5) Disassemble lower footrest parts by removing carpets (250) and (251) from crossbar assemblies (248) and (249), respectively.

(a) Remove upper and lower clamshells (254) and (256) from crossbar assembly (248) by removing eight nuts (258) and eight screws (259).

(b) Remove upper and lower clamshells (255) and (257) from crossbar assembly (249) by removing eight nuts (258) and eight screws (259).

G. Back Assembly (See IPC Figure 1, Sheet 1.)

(1) Slip back cover (1) from seat back assembly. From aft side of seat back assembly and while removing cover (1), disconnect literature pocket bungee cords (4) and (5) from back structure assembly (8).

(2) Remove cords (4) and (5) from cover assembly (1).

(3) Remove cushion assembly (3) and pillow assembly (2) from seat back structure (8).

(4) From the longer leg of the seat back structure assembly (8) remove nut (10), washer (11), bolt (12), washer (13) and spacer (14).

(5) Remove bushing (15), washer (16), angle (17), channel (18) and clip (19).

(6) From the shorter leg of the seat back structure assembly (8) remove bushing (20), washer (21), shim (22), angle (23) and channel (24).

H. Inboard and Outboard Armcap Assemblies (See IPC Figure 1, Sheet 2.)

(1) Remove ash tray assembly (90) from armcap assemblies (93) and (104) by lifting up and forward past fully opened ash tray cover assembly (114).

Applicable on usage code C, Z only. Remove ash tray assembly from armcap assemblies by lifting straight up at ash tray escutcheon.

(2) Remove ash tray escutcheon assemblies (95) and (106) from inboard and outboard armcap assemblies (93) and (104) by removing screws (96) and (107), respectively.

(3) Remove each armcapassembly (93) and (104) by removing two screws (94) and two screws (105), respectively.

(4) Slide each armcap assembly forward until it stops. Spread sides at the rear of armcap assembly with fingers to clear slots in armrest structure assemblies. Remove armcap assemblies (93) and (104).

(5) Slip armcap covers (97) and (108) from armcap structure assemblies (103) and (113), respectively.

(6) Remove top pad (98), two side pads (99) and (100) and stop (101) from inboard armcap assembly (93).

(7) Remove top pad (109), two side pads (110) and stop (111) from outboard armcap assembly (104).

I. Ash Tray Cover Assembly (See IPC Figure 1, Sheet 2.)

(1) Remove ash tray cover assembly (114) from each armrest structure assembly by removing two screws (116) and knob (115). Slide ash tray cover plate (117) aft until it clears armrest structure assembly and remove.

J. Inboard and Outboard Scuff Cap (See IPC Figure 1, Sheet 2.)

(1) Remove each scuff cap (118) by removing one screw (119).

K. Inboard Arm Shell Fairings (See IPC Figure 1, Sheet 1.)

(1) Remove inboard arm shell fairing (67) from inboard armrest structure assembly (129) by removing screws (68).

L. Outboard Arm Fairings (See IPC Figure 1, Sheet 1.)

(1) Remove outboard arm fairings (69) and (71) by removing two screws (70) and (72), respectively.

M. Center Armrest Assembly and Armcap (See IPC Figure 1, Sheet 3.)

(1) Remove center armrest assembly (157) from base assembly (288) by pulling up and forward out of sockets (158) and (162).

(2) Remove center armcap assembly (152) from center armrest assembly (157) by sliding armcap assembly forward until it stops. Lift aft end of armcap assembly to clear slots in armrest assembly and remove.

(3) Remove fitting (149) by removing four screws (150) and one screw (151) from center armrest assembly (157).

(4) Slip cover (153) from armcap structure assembly (155).

(5) Remove pad (154).

N. Recline Cable and Lever Assemblies (See IPC Figure 1, Sheet 2.)

NOTE: For outboard cable and lever assemblies on seats located adjacent to escape hatches, refer to paragraphs (4), (5), (6) and (7) only.

(1) Disconnect terminal end of inboard and outboard cable assemblies (128) from lever assemblies (127) on inboard and outboard armrest structure assemblies.

(2) From each cable assembly (128) remove three clamps (120) by removing three nuts (121), three washers (122) and three screws (123) from within armrest structure assemblies and aft side of bulkhead in base assembly (288). Remove cable assembly.

(3) Remove retaining ring (125) from pin (124) in each armrest structure assembly and remove pin (124), spring (126) and lever assembly (127).

(4) For outboard cable assemblies located adjacent to escape hatches applicable on usage code R-W, AN-AT: remove fairing (132) by removing five screws (133). Disconnect terminal end of cable assembly (143) from lever assembly (142).

(5) From cable assembly (143) remove two clamps (134) by removing two nuts (135), two washers (136) and two screws (137) from within the base assembly (288). Remove cable.

(6) Remove cotter pin (138), washer (139), clevis pin (140), spring (141) and lever assembly (142).

Applicable on usage code R and AN only, remove clevis pin, washer and fork.

(7) Remove clip (146) from seat base assembly (288) by removing one bolt (144) and one washer (145).

O. Inboard and Outboard Armrest Structure Assemblies (See IPC Figure 1, Sheet 2.)

(1) Remove inboard armrest structure assembly (129) by removing three bolts (130) and three washers (131).

(2) Remove outboard armrest structure assembly by removing three bolts and three washers.

P. Breakover Assembly (See IPC Figure 1, Sheet 2.)

(1) From the aft underside of seat base assembly (288) remove breakover assembly (73) from aft end of each seat lock (89) by removing nut (74), washer (75) and bolt (76).

(2) Disassemble breakover assembly (73) by removing bolt (77), washer (78), spring (79), stop (80), spacer (81), yoke (82) and pin (84) from block (85).

Q. Seat Lock (See IPC Figure 1, Sheet 2.)

(1) Remove spring (86).

(a) Applicable on usage code A-B, R, X-Y, AN only, remove spring, cotter pin and spring helper pin.

(2) Disconnect cable assemblies and loosen nut (87) and washer (88) at forward end of lock assembly. Remove seat locks (89) by lowering from between mountings on underside of seat base assembly (288).

R. Seat Belt Fittings (See IPC Figure 1, Sheet 5.)

(1) Applicable on usage code A-M, R-V, X-AJ, AN-AS.

(a) Disconnect and remove four fittings (260) from the ball ends of two cable assemblies (267) and two cable assemblies (271).

(b) Applicable on usage code A-J, L-M, R-T, V, X-AF only. Remove one plate (264) from each aft side of seat base assembly (288) by removing two screws (265) and two screws (266). Remove one plate (261) from each plate (264) by removing two nuts (262) and two screws (263).

(c) Applicable on usage code A-J, L-M, R-T, V, X-AF only. Remove one plate (268) from under seat base assembly beneath center armrest by removing two nuts (269) and two screws (270).

(d) Applicable on usage code A-J, L-M, R-T, V, X-AF only. Remove inboard and outboard seat belt cable assemblies (267) and center seat belt cable assembly (271) from seat base assembly.

(2) Applicable on usage code K, N-Q, U, W, AG, AK-AM, AR,AT.

(a) Applicable on usage code N-Q, W, AK-AM, AT only. Disconnect and remove four seat belt attach yokes (272) from two absorber assemblies (283) and one center absorber assembly (287).

(b) Remove inboard energy absorber support (277) from seat base assembly (288) by removing two screws (279) and two screws (280).

(c) Remove outboard energy absorber support (278) from seat base assembly (288) by removing two screws (279) and two screws (280).

(d) Remove one dust seat (281) and one plate (282) from under each energy absorber support (277) and (278).

(e) On each energy absorber support (277) and (278), remove cotter pin (273), washer (274), clevis pin (275) and roller (276).

(f) Remove inboard and outboard absorber assemblies (283) by lifting up through base assembly (288).

(g) Remove center absorber assembly (287) by removing two screws (285) from under seat base assembly (288) beneath center armrest. Remove energy absorber plate (284) and seal (286).

S. Foot Assembly (See IPC Figure 1, Sheet 4.)

(1) Remove leg fairing assembly (57) from seat leg assembly (314) by removing five screws (58).

(2) Remove foot assembly (198) from seat leg assembly (314) by removing two nuts (199), two washers (200) and two screws (201).

(3) Remove four pins (202) from fittings (209) and (219) and remove tube (203).

(4) From aft fitting (209) remove cotter pin, clevis pin (204), plunger (205), driver (206), spring (207) and pin (208).

(5) From forward fitting (219) remove cotter pin, nut (210), two washers (211), screw (212), nut (213), bolt (214), block (215), wedge (216), plunger (217) and spring (218).

T. Blanket Stowage Assembly (See IPC Figure 1, Sheet 3.) Applicable on Usage Code N-Q, W, AK-AM, AT.

(1) Remove blanket stowage assembly (173) from under seat base assembly (288) by removing five nuts (165) and five screws (166) from aft rail of seat base assembly and three nuts (169) and three screws (170) from forward bulkhead of seat base assembly.

(2) Remove clip (172) from blanket stowage assembly (173).

(3) Remove clip (167) from blanket stowage assembly by removing one nut (174) and one screw (175).

(4) Remove bracket (168) and channel (171) from blanket stowage assembly by removing one nut (174) and one screw (175).

(5) Disassemble blanket stowage assembly by removing washer (176) and latch (177) from pan (178).

U. Legrest Attach Hook (See IPC Figure 1, Sheet 3.) Applicable on Usage Code G, K, U, AD, AG, AR.

(1) Remove two legrest hooks (190) and two legrest hooks (191) from under seat base assembly (288) beneath both seat places by removing eight nuts (192), eight washers (193), four washers (194), four bolts (195) and four bolts (196).

(2) Remove two legrest latches (189) and two springs (184) from legrest hook pairs (190) and (191) by removing two nuts (179), two washers (180), two washers (181), two spacers (182), two screws (183), two screws (185), four washers (186), two spacers (187) and two screws (188).

V. Base Assembly (See IPC Figure 1, Sheet 5.)

(1) Remove bead (301) from seat pan (302).

(2) Remove four bushings (289) from pivots (290), (291) and (292).

(3) Remove pivots (290), (291) and (292).

(4) Remove forward rail (294) by removing four nuts (295), four washers (296), two bolts (297) and two bolts (298). Remove cam (300) and pin (229).

(5) Remove two pans (302) by removing eight screws (303).

(6) Remove forward socket (158) by removing four nuts (161), four washers (160) and four screws (159).

(7) Remove rear socket (162) by removing two screws (163).

(8) Remove energy absorber tubes (304) and (305) by removing four cotter pins.

(9) Remove bead (307) from fairing (306).

(10) Remove pin assembly. Remove ring (308) and spring (309) from pin (310).

(11) Remove aft rail (311) by removing three nuts (312) and three bolts (313).

(12) Remove food tray stops (45), (46) and (47) by removing eight bolts (48) and eight washers (49).

(13) Remove leg assembly (314) by removing two bolts (315), two washers (316), two bolts (317), one nut (318), one washer (319), one spacer (320) and one bolt (321).

3. Cleaning

A. General

(1) Clean upholstery covers installed over foam with soap and water as cleaning solvents are injurious to foam rubber.

(2) Use any standard commercial dry-cleaning procedure on a cover which has been removed.

CAUTION: REMOVE ALL RUBBER CORDS BEFORE APPLYING DRY CLEANING SOLVENT TO COVER TO PREVENT DETERIORATION.

(3) Clean hard thermoplastic fairings with cleaning agent specified in paragraph 3.D.(10), or equivalent.

(4) Clean leather trim surfaces with soap and water or with cleaning agent specified in paragraph 3.D.(10).

(5) Clean carpet trim surfaces with cleaning agents specified in paragraphs 3.D.(1), (2), (3) and (4).

(6) Clean metal parts contaminated with oil or grease with cleaning solvent specified in paragraph 3.D.(9), or equivalent.

WARNING: USE CLEANING SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND AVOID CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(7) Clean foam rubber with soap and water.

(8) Clean metal adjacent to cemented Velcro tape with a water moistened cloth.

B. Types of Cleaning Agents

(1) No single type of cleaning agent is completely effective in the removal of all soiling;each product has its limitations. The instructions given on the product containers should be carefully followed to insure best results.

(2) Concentrated detergent preparations, commonly called upholstery shampoo, are effective in removing dry or water-borne soil. Recommended detergent preparations are specified in paragraph 3.D.(1), (2), (3) and (4).

(3) Solvent type cleaning agents are effective in removal of oil-type soil or grease spots. Recommended solvent type cleaning agents are specified in paragraph 3.D.(5), (6) and (7). Solvent impregnated powder, specified in paragraph 3.D.(8), may be used instead of solvent cleaning agents.

C. Cleaning Procedure

(1) Vacuum upholstery thoroughly, or brush with a medium stiff bristle upholstery or clothing brush. Do not pound or beat.

(2) Test material to be cleaned by first applying cleaning agent to a small inconspicuous area of material.

(3) Use solvent type cleaning agent or solvent impregnated powder to remove oil-type soil or grease stains. Use cleaning materials sparingly without saturating fabric to avoid damage to foam. Apply cleaning agent with a clean soft cloth and avoid spreading a stain by working from the outer edges toward the center.

WARNING: WORK IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS. KEEP AWAY FROM OPEN FLAMES.

NOTE: Solvents should be evaporated rapidly from the fabric surface by directing an air stream from a vacuum cleaner or by fanning toward the material to avoid formation of rings.

(4) Mix upholstery shampoo as directed on container and apply to a small area (approximately one square foot) with a small brush. Liberal application will aid in loosening soil.

(5) Roll a clean turkish towel or other absorbent cloth into a cylindrical shape and wipe off detergent and soil. Rotate rolled towel frequently to present a clean section to upholstery fabric surface.

NOTE: Soil is absorbed or transferred to clean towel by this procedure. Vigorous rubbing may be required to obtain even soil removal and to avoid a blotching appearance after drying.

(6) Repeat procedures in steps 3.C.(4) and 3.C(5) over entire surface of upholstery.

D. Materials

Use materials recommended or equivalents.

	MATERIAL	IDENTIFICATION	SOURCE
(1)	Upholstery cleaner	Foam Cleaner	E. I. Du Pont de Nemours & Co., Wilmington, Delaware
(2)	Upholstery cleaner	Glamorene	Glamorene Inc. 270 Park Avenue New York, New York

	MATERIAL	IDENTIFICATION	SOURCE
(3)	Upholstery cleaner	Mystic Foam	Mystic Foam Corp. Cleveland, Ohio
(4)	Upholstery cleaner	Duo-Dellay	Duo-Dellay Products Co. 4201 Puleshi Highway B ltimore, Maryland
(5)	Upholstery cleaner	Du Pont Dry Clean	E.I. Du Pont de Nemours & Co., Wilmington, Delaware
(6)	Upholstery cleaner	Carbone Instant Foam Lather	Carbone Corporation 30-50 Greenpoint Avenue Long Island City 1, N. Y.
(7)	Upholstery cleaner	Carbone Cleaning Fluid	Carbone Corporation 30-50 Greenpoint Avenue Long Island City 1, N. Y.
(8)	Upholstery cleaner	Powder-ene	Von Schroder Mfg. Co. Racine, Wisconsin
(9)	Cleaning solvent	Fed. Spec. P-S-661	Optional
(10)	Cleaning solvent	Sta-Lube	Sta-Lube, Inc. 19510 So. Alameda Compton, California
(11)	Cement	EC-1300	Minnesota Mining & Mfg. St. Paul, Minnesota
(12)	Cement	T-161	American Latex Products Corp., Hawthorne, Calif.
(13)	Abrasive cloth	No. 600 to 800 grade. Fed. Spec. P-C-451	Optional
(14)	Crocus cloth	Fed. Spec. P-C-458	Optional
(15)	Fiber strips	1-inch wide Velcro	Vel-Cro Sales Corp. 681 Fifth Avenue New York 22, New York
(16)	Wrapping paper	Fed. Spec. UU-P-271	Optional
(17)	Tape	Fed. Spec. JAN-P-127	Optional

	MATERIAL	IDENTIFICATION	SOURCE
(18)	Abrasive cloth	No. 400 grade. Fed. Spec. P-C-451	Optional
(19)	Paint	Gold Pigmented Clear Lacquer #CC1401 Gold #8780	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(20)	Paint	Clear Lacquer #8780	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(21)	Paint	Textured "Uni-chrome" 6400-293 Matsu Gray	Metal and Thermit Corp. 100 Park Avenue New York 17, New York
(22)	Paint	Semi-Gloss Lacquer #38-H-700 Matsu Gray	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(23)	Paint	Textured "Uni-chrome" 6400 Stock Black	Metal and Thermit Corp. 100 Park Avenue New York 17, New York
(24)	Paint	Lacquer #38-J-519 Charcoal Brown	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(25)	Paint	Textured "Uni-chrome" 6400-249 Pearl Gray	Metal and Thermit Corp. 100 Park Avenue New York 17, New York
(26)	Paint	Semi-Gloss Lacquer #38-H-21 Pearl Gray	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(27)	Paint	Vinyl Phenolic #169-G-595 Milano Green	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(28)	Paint	Vinyl Phenolic #169-W-515 Pearl White	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(29)	Paint	Semi-Gloss Lacquer #38-W-536 Pearl White	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California

4. Inspection

A. General

Where doubt exists concerning serviceability of standard AN, NAS, MS parts, the part should be renewed.

B. Visual Inspection

Under strong light, preferably under magnification, visually inspect all parts as applicable, for scored or stripped threads, cracks, nicks, scratches, dents, corrosion and excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of parts.

C. Inspection Requirements

INDEX NO.	NOMENCLATURE	INSPECTION
(90)	Ash Tray Assembly	Wear, appearance, caking
(151)	Armrest Assembly	Wear, cracks, scratches, loosened rivet
(17), (23), (148)	Angle	Distortion, cracks
(283), (287)	Absorber Assembly	Distortion, wear, cracks, breaks, broken or frayed wire, security of swaged ball.
(15), (20), (40), (41), (42), (227), (228), (289)	Bushing	Wear
(85), (215)	Block	Cracks, breaks
(288)	Base Assembly	Distortion, cracks, loosened nut plates and rivets
(215)	Block	Wear, cracks
(28), (168), (230), (231)	Bracket	Distortion, cracks
(301), (307)	Bead	Wear

INDEX NO.	NOMENCLATURE	INSPECTION
(128), (143)	Cable Assembly	Kinks, wear, broken or frayed wire, security of swaged ball, stripped terminal threads, damaged housing.
(267), (271)	Cable Assembly	Kinks, wear, broken or frayed wire, security of swaged ball.
(1), (50), (51), (97), (108), (153)	Cover	Rips, tears, burns, cuts, scratches and wear
(118)	Cap Assembly	Wear, scratches
(52), (3)	Cushion	Wear, tears, damage, loss of resiliency
(4), (5)	Cord	Wear, breaks
(6), (19), (146), (167), (172)	Clip	Cracks, breaks, distortion
(18), (24), (171)	Channel	Distortion, cracks
(300)	Cam	Distortion, nicks, cracks, wear
(56)	Container Assembly	Rips, tears
(120), (134)	Clamp	Cracks, breaks
(248), (249)	Crossbar Assembly	Distortion, cracks, broken teeth, sheared pin, bend tube
(254), (255), (256), (257)	Clamshell	Cracks, breaks
(250), (251)	Carpet	Tears, burns, stains, wear
(206)	Driver	Distortion, wear, cracks
(106)	Escutcheon	Wears, scratches and appearance

INDEX NO.	NOMENCLATURE	INSPECTION
(44), (57), (61), (64), (65), (67), (69), (71), (132), (156)	Fairing	Dents, gouges, wear, cuts, abrasions, appearance
(209), (219)	Fitting	Distortion, wear, cracks
(91), (149)	Fitting	Wear, cracks, broken threads
(260)	Fitting Assembly	Distortion, cracks, breaks
(306)	Fairing	Bends, cracks
(190), (191)	Hook	Distortion, cracks, breaks
(115)	Knob	Wear, scratches, appearance
(25), (31), (177), (189)	Latch	Wear, sticking
(89)	Lock	Operation
(127)	Lever Assembly	Wear, cracks, broken nut plate
(314)	Leg Assembly	Distortion, cracks, loosened nut plates and rivets
(7), (84), (124), (140), (202), (204), (208), (238), (239), (241), (242), (275)	Pin	Wear, distortion, cracks, breaks
(117)	Plate	Wear, scratches, appearance
(53), (55), (98), (99), (100), (109), (110), (154)	Pad	Wear, tears, stiffness
(205), (217)	Plunger	Distortion, wear, cracks
(2)	Pillow Assembly	Wear, damage, loss of resiliency

INDEX NO.	NOMENCLATURE	INSPECTION
(147), (290), (291), (292)	Pivot	Distortion, wear, cracks
(178), (302)	Pan	Bends, cracks, breaks
(164), (261), (264), (268), (282), (284)	Plate	Distortion, cracks, breaks
(243)	Pawl	Distortion, cracks, breaks
(294), (311)	Rail	Cracks, breaks, nicks, wear
(125), (240)	Ring	Cracks, breaks
(276)	Roller	Wear, breaks, cracks
(43)	Support	Wear, distortion, breaks
(79)	Spring	Cracked, broken or deformed, free length 1.00 inch
(45), (46), (47), (80), (101), (111)	Stop	Damage, distortion, cracks, breaks
(14), (34), (35), (81), (182), (187), (320)	Spacer	Wear, distortion
(86)	Spring	Cracked, broken or deformed, free length 2.75 inches
(309)	Spring	Cracked, broken or deformed, free length 1.62 inch
(126), (141), (184), (207), (218), (234), (235)	Spring	Cracked, broken or deformed
(103), (113), (129)	Structure Assembly	Distortion, cracks, loosened nut plates and rivets
(281), (286)	Seal	Tears, rips
(277), (278)	Support	Distortion, wear, cracks, breaks

INDEX NO.	NOMENCLATURE	INSPECTION
(158), (162)	Socket Assembly	Distortion, cracks, breaks
(33)	Table Assembly	Wear, distortion, broken bond
(203), (304), (305)	Tube	Bends, cracks, breaks
(266)	Triplate	Distortion, cracks, broken teeth
(216)	Wedge	Wear, cracks
(13), (16), (21), (181), (229)	Washer	Cracks
(82), (272)	Yoke	Cracks, breaks

5. Repair

A. General

(1) Minor nicks and scratches may be removed from aluminum alloy parts by polishing with oxide abrasive cloth specified in paragraph 3.D.(13), or equivalent. Clean all parts thoroughly after polishing.

(2) Minor nicks and scratches may be removed from non-critical steel parts by polishing with crocus cloth specified in paragraph 3.D.(14), or equivalent. Clean all parts thoroughly after polishing.

(3) Use standard shop practice for minor repair of sheet metal and/or riveted pieces.

(4) Components not satisfying inspection requirements must be repaired before seat is returned to service or storage. Repairs are listed in the following paragraphs. Components which require inspection and are not listed in these paragraphs should be renewed if damaged or worn.

B. Cemented Foam

(1) (See IPC Figure 1, Sheet 1.) All foam pads except (52) are cemented to the metal structure. The cemented joint normally is stronger than the foam itself, and usually the foam will be damaged beyond use during removal operations. Foam damaged during removal should not be reinstalled. Short sections of the cemented joint can be opened and re-cemented.

(2) To remove foam for renewal, use a sharp thin knife to cut the foam close to the cemented joint while pulling foam away from the structure. Most of the foam should come off leaving a thin layer of foam and cement on the metal. If a relatively even surface is obtained, new foam may be installed over this thin layer. If the layer is thick or uneven, strip down to bare metal before installing new foam. Use commercial grade acetone as solvent to soak layer before using a dull metal blade to scrape layer from metal.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

CAUTION: ACETONE CAUSES FOAM BREAKDOWN. DO NOT USE ACETONE IN MAKING MINOR REPAIRS. DO NOT REUSE FOAM SOAKED BY ACETONE.

(3) If foam is torn or loose, but is otherwise usable, cement the tear or the loose joint. Apply cement specified in paragraph 3.D.(11), or equivalent, to both sides of joint and allow to air dry until tacky. Press joint together and hold briefly.

NOTE: There is some local stiffening of foam at cemented joints. Avoid heavy or extensive cementing on seat foam surfaces or edges.

(4) Instructions contained in paragraphs 5.B.(1), (2) and (3) apply to fairings cemented to the armrests. The fairings will possibly be damaged beyond use during removal. The metal must be scraped clean before a new fairing is cemented in place.

C. Fiber Strips (Velcro)

(1) Fixed strips of Velcro are cemented to the seat back and seat base structure. To remove strip, soak with acetone.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(2) To install or repair a loosened strip, wipe metal surface clean and dry. Coat metal and Velcro with cement specified in paragraph 3.D.(11), or equivalent, and allow to air dry until tacky. Press joint together and hold briefly.

(3) Velcro strips are sewn to the cover material. If short sections of Velcro are loose, repair by sewing.

D. Paint

(1) Painted areas on the seat include the food tray shell assembly (37), the food tray support assembly (39), the dummy food tray fairing (44), the rear center hinge fairing (61), the seat back fairings (64) and (65) and the arm shell fairings (67), (69) and (71).

(2) Nicks, scratches, gouges and scuff marks on these items mar the general appearance of the entire seat and should be restored to their original finish.

(3) Painted areas listed in paragraph 5.D.(1) damaged with shallow cuts and abrasions may be refinished as follows:

NOTE: Deep cuts or gouges to thermoplastic material cannot be satisfactorily repaired.

(a) Sand the damaged area lightly with abrasive cloth as specified in paragraph 3.D.(18).

NOTE: Extensive sanding of thermoplastic material removes the original "haircell" surface texture.

(b) Clean the sanded area with a clean lint-free cloth moistened in acetone.

WARNING: USE ACETONE IN A WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF THE VAPORS AND CONTACT WITH THE SKIN. KEEP AWAY FROM OPEN FLAMES.

(c) Paint the damaged areas with finishes as specified below.

NOTE: Thermoplastic components will contain either integral or surface color. Do not locally refinish or touch-up thermoplastic material containing integral color unless entire component is painted.

Applicable on usage code A, B, Q, X, Y, AN.

Paint the food tray shell assembly (37), the food tray support assembly (39), the dummy food tray fairing (44), the rear center hinge fairing (61), the seat back fairings (64) and (65) and the arm shell fairings (67), (69) and (71) with one coat of lacquer as specified in paragraph 3.D.(19). Allow to air dry dust free for two hours. Apply second coat of lacquer as specified in paragraph 3.D.(20).

Applicable on usage code C, Z.

Paint the food tray support assembly (39) with one coat of paint as specified in paragraph 3.D.(21).

Paint the rear center hinge fairing (61), the seat back fairings (64) and (65) and all other visible painted metal surfaces with lacquer as specified in paragraph 3.D.(22).

Applicable on usage code D, E, F, AA, AB, AC.

Paint the food tray support assembly (39) with one coat of paint as specified in paragraph 3.D.(23). Allow to dry thoroughly and apply second coat of lacquer as specified in paragraph 3.D.(24).

Paint the rear center hinge fairing (61), the seat back fairings (64) and (65) and all other visible painted metal surfaces with lacquer as specified in paragraph 3.D.(24).

Applicable on usage code G, H, J, S, T, AD, AE, AF, AP, AQ.

Paint the food tray support assembly (39) with one coat of paint as specified in paragraph 3.D.(25).

Paint the rear center hinge fairing (61), the seat back fairings (64) and (65) and all other visible painted metal surfaces with lacquer as specified in paragraph 3.D.(26).

Applicable on usage code K, U, AG, AR.

Paint the food tray support assembly (39), the rear center hinge fairing (61), the seat back fairings (64) and (65) and all other visible painted metal surfaces with one coat of lacquer as specified in paragraph 3.D.(27).

Applicable on usage code L-Q, V, W, AH-AM, AS, AT.

Paint the food tray support assembly (39) with one coat of paint as specified in paragraph 3.D.(28).

Paint the rear center hinge fairing (61), the seat back fairing (64) and (65) and all other visible painted metal surfaces with one coat of lacquer as specified in paragraph 3.D.(29).

6. Assembly

A. Base Assembly (See IPC Figure 1, Sheet 5.)

(1) Install leg assembly (314) using two bolts (315), two washers (316), two bolts (317), one nut (318), one washer (319), one spacer (320) and one nut (321).

(2) Install food tray stops (45), (46) and (47) using eight washers (49) and eight bolts (48).

(3) Install aft rail (311) using three bolts (313) and three nuts (312).

(4) Install spring (309) and ring (308) on pin (310). Install pin assembly through base assembly and rail.

(5) Install two beads (307) on fairing (306) using cement as specified in paragraph 3.D.(12).

(6) Install energy absorber tubes (304) and (305) using four cotter pins.

(7) Install rear socket (162) in center bay using two screws (163).

(8) Install forward socket (158) using four screws (150), four washers (160) and four nuts (161).

(9) Install two seat pans (302) using eight screws (303).

(10) Install forward rail (294) using two bolts (298), two bolts (297), four washers (296) and four nuts (295). Install cam (300) and pin (229) in rail.

(11) Install pivots (290), (291) and (292).

(12) Install four bushings (289) in pivots (290), (291) and (292).

(13) Install bead (301) on aft lip of each seat pan (302) using cement in paragraph 3.D.(12).

B. Legrest Attach Hook (See IPC Figure 1, Sheet 3.) Applicable on Usage Code G, K, U, AD, AG, AR.

(1) Assemble two legrest latches (189) and two springs (184) on legrest hook pairs (190) and (191) using two screws (188), two spacers (187), four washers (186), two screws (185), two screws (183), two screws (182), two washers (181), two washers (180) and two nuts (179).

C. Blanket Stowage Assembly (See IPC Figure 1, Sheet 3.) Applicable on Usage Code N-Q, W, AK-AM, AT.

(1) Install latch (177) on pan (178).

(2) Install two washers (176) on pan (178) using cement as specified in paragraph 3.D.(12).

(3) Install bracket (168) and channel (171) on blanket stowage assembly (173) using one screw (175) and one nut (174).

(4) Install clip (167) on blanket stowage assembly (173) using one screw (175) and one nut (174).

(5) Position clip (172) on blanket stowage assembly (173) and install both on underside of seat base assembly (288) using five screws (166) and five nuts (165) in aft rail and three screws (170) and three nuts (169) in forward bulkhead.

D. Foot Assembly (See IPC Figure 1, Sheet 4)

(1) Install spring (218), plunger (217), wedge (216), block (215), bolt (214), nut (213), screw (212), two washers (211), nut (210) and cotter pin from forward fitting (219).

(2) Install pin (208), spring (207), driver (206), plunger (205) clevis pin (204) and cotter pin in aft fitting (209).

(3) Install tube (203) in two fittings (209) and (219) using four pins (202).

(4) Install foot assembly (198) on seat leg assembly (314) using two screws (201), two washers (200) and two nuts (199).

(5) Install leg fairing assembly (57) on seat leg assembly (314) using five screws (58).

E. Seat Belt Fittings (See IPC Figure 1, Sheet 5.)

(1) Applicable on usage code A-M, R-V, X-AJ, AN-AS

(a) Applicable on usage code A-J, L-M, R-T, V, X-AF only. Install inboard and outboard seat belt cable assemblies (267) and center seat belt cable assembly (271) in seat base assembly.

(b) Applicable on usage code A-J, L-M, R-T, V, X-AF only. Install plate (268) under seat base assembly beneath center armrest using two screws (270) and two nuts (269).

(c) Applicable on usage code A-J, L-M, R-T, V, X-AF only. Install plate (264) on plate (261) using two screws (263) and two nuts (262). Install assembled plates (264) and (261) on each aft side of seat base assembly (288) using two screws (265) and two screws (266).

(d) Install four fittings (260) on the ball ends of two cable assemblies (267) and two cable assemblies (271).

(2) Applicable on usage code K, N-Q, U, W, AG, AK-AM, AR, AT.

(a) Install energy absorber plate (284), seal (286) and center absorber assembly (287) under seat base assembly (288) beneath center armrest using two screws (285).

(b) Insert inboard and outboard absorber assemblies (283) into openings in each aft end of seat base assembly (288).

(c) Install roller (276), clevis pin (275), washer (274) and cotter pin (273) on each energy absorber support (277) and (278).

(d) Install one plate (282) and one dust seal (281) on each absorber assembly (283) aligning fasten holes at same time.

(e) Install inboard energy absorber support (277) and outboard energy absorber support (278) using four screws (279) and four screws (280).

(f) Applicable on usage code N-Q, W, AK-AM, AT only. Install four seat belt attach yokes (272) on the ball cable ends of two absorber assemblies (283) and one center absorber assembly (287).

F. Seat Lock (See IPC Figure 1, Sheet 2.)

(1) Position inboard and outboard seat lock (89) in place between mountings on underside of seat base assembly (288). Tighten nut (87) and washer (88) against each mounting.

(2) Install spring (86).

(3) Applicable on usage code A-B, R, X-Y, AN only. Install spring, spring helper pin and cotter pin.

G. Breakover Assembly (See IPC Figure 1, Sheet 2.)

(1) Assemble breakover assembly (73) by installing pin (84), yoke (82), spacer (81), stop (80), spring (79), washer (78) and bolt (77) in block (85).

(2) Install breakover assembly (73) on aft end of each seal lock (89) using bolt (76), washer (75) and nut (74).

H. Inboard and Outboard Armrest Structure Assemblies (See IPC Figure 1, Sheet 2.).

(1) Install inboard armrest structure assembly (129) using three washers (131) and three bolts (130).

(2) Install outboard armrest structure assembly using three washers and three bolts.

(3) Install inboard and outboard food tray fittings (91) using three screws (92).

I. Recline Cable and Lever Assemblies (See IPC Figure 1, Sheet 2.)

NOTE: For the installation of outboard cable and lever assemblies on seats located adjacent to escape hatches, refer to paragraph (4).

(1) Install lever assembly (127) in each armrest structure assembly using pin (124), spring (126) and retaining ring (125).

(2) Route cable assembly (128) through ash tray opening in each armrest structure assembly and down behind bulkhead in seat base assembly (288). Install three clamps (120) using three screws (123), three washers (122) and three nuts (121) in armrest structure assembly and seat base assembly.

(3) Connect terminal end of each cable assembly (128) to each lever assembly (127).

(4) Applicable on usage code R-W, AN-AT only.

(a) Install lever assembly (142) on base assembly (288) using clevis pin (140), spring (141), washer (139) and cotter pin (138).

(b) Applicable on usage code R and AN only. Install clip (146) on seat base assembly (288) using one washer (145) and one bolt (144).

(c) Install cable assembly (143) using two clamps (134), two screws (137), two washers (136) and two nuts (135).

(d) Connect terminal end of cable assembly (143) to lever assembly (142).

(e) Install fairing (132) over lever assembly (142) on seat base assembly using five screws (133).

J. Center Armrest Assembly and Armcap (See IPC Figure 1, Sheet 3.)

(1) Place pad (154) on armcap structure assembly (155) and install cover (153).

(2) Install fitting (149) on center armrest assembly (157) using four screws (150) and one screw (151).

(3) Install armcap assembly (152) on center armrest assembly (157) by sliding armcap assembly aft until fittings mesh with slots in each side of armrest assembly. Push in with palm of hand on each side of armcap assembly simultaneously to engage and slide aft until stop.

(4) Install center armrest assembly (157) in seat base assembly (288) by inserting into sockets (158) and (162).

K. Outboard Arm Fairings (See IPC Figure 1, Sheet 1.)

(1) Install outboard arm fairings (69) and (71) using two screws (70) and (72), respectively.

L. Inboard Armshell Fairing (See IPC Figure 1, Sheet 1.)

(1) Install inboard armshell fairing (67) on inboard armrest structure assembly (129) using screws (68).

M. Stewardess Step (See IPC Figure 1, Sheet 1.) Applicable on Usage Code N-Q, W, AK-AM, AT.

(1) Install step (59) using two screws (60).

N. Inboard and Outboard Scuff Cap (See IPC Figure 1, Sheet 2.)

(1) Install scuff cap (118) on aft end of both inboard and outboard armrest structure assembly using one screw (119).

Q. Ash Tray Cover Assembly (See IPC Figure 1, Sheet 2.)

(1) Install knob (115) on ash tray cover plate (117) using two screws (116). Slide ash tray cover assembly (114) into guides in each armrest structure assembly.

P. Inboard and Outboard Armcap Assemblies (See IPC Figure 1, Sheet 2.)

(1) Place top pad (109) and two side pads (110) on outboard armcap structure assembly (113). Install stop (111) on underside of armcap structure assembly using two screws (112).

(2) Slip cover (108) over outboard armcap structure assembly (113).

(3) Place top pad (98) and two side pads (99) and (100) on inboard armcap structure assembly (103). Install stop (101) on underside of armcap structure assembly using two screws (102).

(4) Slip cover (97) over inboard armcap structure assembly (103).

(5) Install inboard and outboard armcap assemblies (93) and (104), respectively on armrest structure assemblies by sliding aft until fittings in armcap assemblies mesh with slots on each side of armrest structure assemblies. Push in on each side of armcap assembly simultaneously with palm of hand to engage and slide aft to stop.

(6) Install two screws (94) and two screws (105) in armcap assemblies (93) and (104), respectively.

(7) Install ash tray escutcheon assemblies (95) and (106) in inboard and outboard armcap assemblies (93) and (104) by removing screws (96) and (107), respectively.

(8) Applicable on usage code C, Z only. Install ash tray assemblies in armcap assemblies by inserting straight down into ash tray openings.

(9) Insert ash tray assembly (90) in armcap assemblies (93) and (104) past fully opened ash tray cover assembly (114).

Q. Back Assembly (See IPC Figure 1, Sheet 1.)

(1) Install food tray latch bracket (28).

(2) Install latch assembly (25) using two shims (27) and two screws (26) on bracket (28).

(3) Install angle (23), channel (24), shim (22), washer (21) and bushing (20) on the shorter leg of the seat back structure assembly (8).

(4) Install clip (19), channel (18), angle (17), washer (16) and bushing (15) on the longer leg of the seat back structure assembly using bolt (12), washer (13), spacer (14), washer (11) and nut (10).

(5) Install cushion assembly (3) and pillow assembly (2) on seat back structure (8).

(6) Install cords (4) and (5) in cover assembly (1).

(7) Pull cover assembly (1) over seat back and dress carefully.

(a) Seat appearance depends on cover dressing and is obtained by seam alignment. Even distribution of cover material on the foam is essential. This must be obtained by working the cover with the palm of the hand so that it lies in approximate positions before it is fastened down. The fold of all cord seams must lie on the top or bottom, front or back, but never on the side of the foam.

(b) The seam fold must be worked onto the top or the bottom, front or back of the foam as the cover is worked into place. In the wings beside the headrest use a blunt, rounded-end rod to push the seam fold into position. Use fingers around remainder of seat where accessible. Normally, some portions of the seam fold are missed or will shift out of position. They are located by feeling along the seam edges after the cover is installed and then are adjusted by use of a sharp pointed awl. Slip point of awl 1/4 to 3/8 inch into material beside the seam fold. Move awl handle to pick up seam fold and work into position. Avoid jabbing point of awl into foam.

(c) Velcro engagement must be obtained with mating edges flush and even so the cover is pulled evenly. Properly positioned, neither section of Velcro will be visible when fastened. To obtain proper dress in square corners of tray recess, fasten Velcro up to the corner to see if the corner is square. If the cover is so spaced that material will not fit into the corner (short), or if the material buckels in corner (long), use the point of the awl to hook Velcro for the side pull that will peel the corner open for several inches to each side. Work the cover material with the hands to provide more material in a short corner or less material in long corner. Re-engage Velcro toward corner to obtain a square corner.

(d) To install the cover, work the top over seat back top with seams matching the edge of the foam. Dress seam folds to lie on back front, but not sides (use rod and awl point).

(e) Dressing seam folds and working cover smooth, continue installation over front and sides of foam until bottom cover corners can be worked over foam to position the whole cover on the foam. Smooth and work cover for even distribution and proper fit. The key point is the inside rear corner at the base of the tray recess. The tip of the seam joint must lie even with the bottom edge of the material panel with the cover smooth and even but unfastened. If low, cover material has been worked too far toward bottom of foam; if high, cover has not been worked far enough down over foam.

(f) When cover and seams are properly dressed and aligned on foam, tack Velcro at bottom corners. Obtain seam alignment with aft foam edges near the center of the back to hold with a long pin through the aft face of the cover into the foam. Dress cover across front fact of foam to give aft edge seam alignment and pin at two to three inch intervals. Work down and up from first pin in center. In essence, the cover is worked into proper fit from base to bottom of headrest and pinned. The final dress is made as the Velcro is fastened along the side of the tray recess in the back.

(g) At the upper rear of the back, center the cutout of the cover evenly over the latch keeper and hook Velcro for an inch or two on each side. Smooth cover and work across top of tray recess, aligning seams while fastening Velcro. To clear the tray, it is important that Velcro makes a square corner in the tray recess corners. Work cover dress as necessary to obtain this result.

(h) Check entire back for neat appearance, even seams, and even and straight cloth pattern. Check that no Velcro or metal is visible.

(i) Install aft panel of back cover in tray recess starting at top with good fit in corners, dress panel downward and toward sides to fasten the Velcro. Engage pocket cords to holes in back structure before fastening Velcro at this point.

R. Fairings (See IPC Figure 1, Sheet 1.)

(1) Install back fairing (65) on the outboard leg of the outboard seat back using four screws (66).

(2) Install back fairing (64) on the inboard leg of the inboard seat back using four screws (66).

(3) Install center hinge fairing (61) on the aft side of the seat base assembly (288) using two screws (62) and two screws (63).

S. Food Tray Assembly (See IPC Figure 1, Sheet 1.) Applicable on Usage Code A, C-E, G-N, Q-S, U, W-X, Z-AB, AD-AK, AM-AP, AR, AT.

(1) Install two bushings (42), four bushings (41) and four screws (40) in support assembly (39).

(2) Install table assembly (33) on support assembly (39) using four screws (32).

(3) Install latch (31) on table assembly (33) using three screws (30).

T. Seat Back and Food Tray (See IPC Figure 1, Sheet 1.)

(1) Install each seat back assembly (8) and food tray assembly or dummy fairing (44) using two pins (7).

(2) Unlatch food tray to pull tray support back and lower tray to horizontal position.

(3) Adjust tray support stops until tray pivot point is 25.5 plus or minus .50 inches from the floor with both stops contacting tray support (39).

(4) Adjust front set screws (40) in tray support (39) to bring top surface of food tray horizontal to floor level.

(5) Move tray installation to stowed position. If food tray does not align with tray support (39), adjust rear set screws (40) in tray support (39).

(6) Move tray installation to stowed position and insure that food tray latches positively.

(7) Add or remove shims (27) behind latch (25) until no play exists between food tray latch and seat back latch.

(8) Raise or lower latch (25) until tang of latch has positive engagement of 0.120 to 0.150 inch with food tray latch.

U. Seat Cushions (See IPC Figure 1, Sheet 1.)

(1) Install pad (53) on base assembly (288).

(2) Install pad (55) and sock (54) onbase frame assembly (288).

(3) Install covers (50) and (51) on cushion (52) by working cover over foam. Dress to obtain seam alignment and smooth with even distribution all around. Dress cover toward sides and forward to fasten Velcro on the underside.

7. Fits and Clearances

Not applicable.

8. Testing

A. Seat Operation

(1) (See IPC Figure 1, Sheet 1.) Sitting in each seat, in turn, lift handle to check reclining action of seat back. Seat back must recline smoothly and lock in position when lever is released.

(2) Lean forward to take weight off seat back. Lift lever and check that back recovers to normal position.

(3) Repeat operations described in steps (1) and (2) at least three times.

(4) Set seat back in reclined position. With lever down, check that seat back can be manually returned to normal position without undue force. Check that seat back locks in normal position.

(5) Apply 35 pounds forward pull at top center of seat back and check that breakover mechanism releases to allow seat to fold forward. If necessary, adjust bolt at breakover mechanism, to adjust compression of spring until correct setting is obtained.

(6) Check operation and position of food tray in open and closed positions. If necessary, adjust as described in paragraphs 6.Q.(5) to (11).

9. Trouble Shooting

PASSENGER SEAT ASSEMBLY

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
A. Recline Lever Will Not Lift or Lifts But Fails to Unlock Seat Back	
(1) Defective seat lock (89). (See IPC Figure 1, Sheet 2.)	Replace seat lock unit. Check lever, clevis, turnbuckle, upper end of cable assembly (128) for bind or breakage. Look up under seat base to observe arm at front of seat lock. Move lever and insure that linkage and cable move with it. Free or replace parts as necessary.
(2) Broken or sticking elements in cable and linkage between lever and seat lock.	
B. Recline Lever Sticks in Raised Position	
(1) Defective spring (86) at seat lock. (See IPC Figure 1, Sheet 2.)	Check through base structure channel for loose, stretched, or broken spring (86). Rectify.
(2) Cable assembly (128) binding.	Check for binding at lower end of cable. Check for binding at upper end of cable. Rectify binding condition.
C. Seat Back Fails to Lock or Recover When Seat Lock Operated	
(1) Defective seat lock (89). (See IPC Figure 1, Sheet 2.)	Replace seat lock (89).
D. Food Tray Fails to Latch Closed	
(1) Defective tray latch (31). (See IPC Figure 1, Sheet 1.)	Check tray latch operation. Replace tray latch (31).
(2) Defective seat latch (25). (See IPC Figure 1, Sheet 1.)	Check seat latch operation. Replace seat latch (25).
(3) Maladjusted latches.	Check latch adjustment; refer to paragraphs 6.T.(6) to (8). Adjust if necessary.
(4) Food tray pivot (32) distorted or sheared. (See IPC Figure 1, Sheet 1.)	Replace food tray assembly (33)

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
E. Food Tray Not Level in Down Position	
(1) Food tray support stops (45), (46) or (47) moved. (See IPC Figure 1, Sheet 1.)	Loosen bolts (48) and adjust stops (45), (46) and (47); refer to paragraph 6.T.(2) and (3).
F. Seat Back Folds Forward Past Normal Position With Light Push	
(1) Maladjusted breakover assembly (73). (See IPC Figure 1, Sheet 1.)	Check breakover adjustment; refer to paragraph 8.A.(5).
(2) Broken breakover assembly (73)	Check breakover assembly for obvious damage. Replace breakover assembly (73) if necessary.
G. Seat Back Fails to Fold Forward on Impact	
(1) Maladjusted breakover assembly (73). (See IPC Figure 1, Sheet 1.)	Check breakover adjustment; refer to paragraph 8.A.(5).
H. Footrest Will Not Lift or Lifts But Fails to Lock	
(1) Broken or sticking elements in footrest assembly at upper pivot. (See IPC Figure 1, Sheet 4.)	Check footrest ratchet pawl (243) and footrest ratchet triplate (226) for bind or breakage. Free or replace parts as necessary.
J. Footrest Crossbar Pivots Without Locking	
(1) Broken pin stop on crossbar assemblies (248) and (249). (See IPC Figure 1 Sheet 4.)	Replace crossbar assembly.

10. Storage Instructions

A. The seat assembly is essentially corrosion resistant and no special preservation is required.

B. For maximum space in storage, demount seat back and tray group and center armrest. Keep removed parts with applicable assembly.

C. Wrap seat in waterproof wrapping paper specified in paragraph 3.D.(16) or a plastic cover. Use tape specified in paragraph 3.D.(17), or equivalent, to secure wrapping paper or cover. Stamp seat assembly part number and date of overhaul on a tag or in a convenient location on seat wrapper.

D. Store seat in a cool dry area, below 68 degrees F., away from sunlight and heat source.

11. Special Tools, Fixtures and Equipment

A. While not essential, a frame or fixture to simulate the mounting provisions in the airplane will assist disassembly and assembly.

B. No other special tools, fixtures or equipment are required.

PASSENGER SEAT ASSEMBLIES - DOUBLE LUXURY

(Convair Part Nos. 22-90490 and 22-93694 Series;
30-94500, 30-94502 and 30-94553 Series)

ATA NO. 25-2-31

Applicable to Models 22(M)-3, 22(M)-4,
22(M)-21-3, 22(M)-22
30-6, and 30-8

July 20/62

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22-92330-852		1	1
22-92331-7		1 - 61	1
22-92332-10		1 - 65	1
22-92332-13		1	1
22-92332-14		1 - 64	1
22-92332-9		1	1
22-92334		1 - 156	1
22-92339-801		1	1
22-92339-802		1	1
22-92339-803		1	
22-92339-804		1	1
22-92352-13		1	1
22-92352-7		1 - 14	1
22-92352-9		1 - 61	1
22-92353		1 - 301	2
22-92353-7		1 - 307	1
22-92355		1 - 32	4
22-92356		1 - [illegible]	1
22-92356-201		1	1
22-92356-7		1 - [illegible]	1
22-92356-851		1	1
22-92357		1 - [illegible]	1
22-92357-7		1 - [illegible]	1
22-92360-9		1 - 6	4
22-92361-1		1 - 44	1

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
22-92364-811		1 - 50	1
22-92364-812		1	1
22-92364-813		1 - 51	1
22-92364-814		1	1
22-92366		1 - 153	1
22-92366-1		1 - 97	1
22-92368-2		1	1
22-92368-201		1	1
22-92368-202		1	1
22-92368-203		1	1
22-92368-3		1 - 108	1
22-92369-203		1 - 147	1
22-92370-203		1 - 132	1
22-92370-204		1	1
22-92371-7		1 - 34	1
22-92371-8		1 - 35	1
22-92374-851		1 - 267	2
22-92374-853		1 - 271	2
22-92375		1 - 152	1
22-92376-201		1	
		1	2
22-92376-7		1 - 98	
		1 - 109	2
22-92377-7		1 - 100	
		1 - 110	3
22-92377-9		1 - 99	1
22-92379		1 - 3	2
22-92380-9		1 - 154	1
22-92382-3		1 - 2	2
22-92389-201		1 - 286	1
22-92389-205		1 - 281	2
22-92392-7		1 - 276	2
22-92395		1 - 260	4
22-92419-7		1 - 241	2
22-92419-9		1 - 242	1
22-92420-7		1 - 229	4
22-92425-201		1	2
22-92425-205		1	2
22-92425-207		1 - 29	2
22-92516		1 - 302	2
22-92518-201		1 - 46	1
22-92518-202		1 - 47	1
22-92518-7		1 - 45	2
22-92519-201		1 - 290	1
22-92519-203		1 - 292	1
22-92520-201		1 - 291	1
22-92531-7		1 - 306	1
22-92531-8		1	1
22-92532-11		1 - 158	1
22-92533-7		1 - 162	1
22-92536		1 - 90	
		1	2
22-92538-201		1 - 117	
		1	2
22-92538-203		1 - 115	
		1	2
22-92538-851		1 - 114	
		1	2
22-92539-1		1 - 95	
		1 - 106	2
22-92540-801		1	1
22-92542-851		1 - 287	1
22-92543-853		1 - 283	2
22-92546-11		1 - 305	1
22-92546-7		1 - 304	1
22-92547-203		1 - 268	
		1 - 284	2
22-92547-205		1 - 264	
		1 - 282	4
22-92550-5		1	2
22-92550-815		1	2
22-92551-1		1 - 39	1
22-92551-7		1 - 43	1
22-92552-5		1 - 33	1
22-92552-205		1	1
22-92553		1 - 155	1

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
22-92554-17		1 - 37	1
22-92554-27		1 - 36	1
22-92554-31		1	1
22-92555		1 - 38	1
22-92557-201		1 - 28	1
22-92558-11		1 - 52	2
22-92558-23		1	2
22-92559-201		1 - 53	2
22-92559-21		1	2
22-92560-801		1	1
22-92560-802		1	1
22-92560-803		1 - 8	1
22-92560-804		1	1
22-92567-205		1 - 146	1
22-92567-206		1	1
22-92567-207		1 - 167	1
22-92567-208		1	1
22-92567-209		1 - 168	1
22-92567-210		1	1
22-92567-211		1 - 171	1
22-92567-213		1 - 172	1
22-92567-215		1 - 164	1
22-92568-10		1	1
22-92568-11		1 - 16	
		1 - 21	2
22-92568-13		1 - 18	
		1 - 24	2
22-92568-15		1 - 23	1
22-92568-16		1	1
22-92568-17		1 - 13	1
22-92568-7		1 - 17	1
22-92568-8		1	1
22-92568-9		1 - 19	1
22-92569-201		1 - 22	1
22-92569-23		1 - 27	2
22-92581		1 - 101	
		1 - 111	2
22-92584-1		1 - 129	1
22-92584-2		1	1
22-92584-851		1	1
22-92584-852		1	1
22-92584-853		1	1
22-92584-854		1	1
22-92586-1		1	1
22-92586-2		1	1
22-92586-3		1	1
22-92586-4		1	1
22-92586-853		1	1
22-92586-854		1	1
22-92587-5		1	1
22-92587-801		1	2
22-92587-803		1 - 73	
		1	3
22-92589		1	1
22-92589-201		1 - 79	
		1	2
22-92591-3		1 - 157	1
22-92596-11		1 - 4	2
22-92599		1 - 59	1
22-93694-1		1	5
22-93694-2		1	5
22-93698-33		1	2
22-93698-807		1	2
22-93698-9		1	2
22-94502-11		1	2
22-94502-9		1 - 9	2
22-94503-207		1 - 127	
		1	2
22-94503-851		1 - 142	1
22-94504-201		1 - 141	
		1 - 126	
		1	3
22-94506-3		1	1
22-94506-4		1	1
22-94507-1		1	1
22-94507-2		1	1

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
22-94510		1	
		1	
		1	3
22-94516		1	2
22-94517-7		1	4
22-94526-11		1 - 82	1
22-94526-9		1	1
2268		1 - 177	1
30-93502-45		1 - 148	1
30-93502-801		1	1
30-93502-802		1	1
30-93502-803		1	1
30-93502-804		1	1
30-93502-805		1 - 288	1
30-93502-806		1	1
30-93502-807		1	1
30-93502-808		1	1
30-93502-815		1	1
30-93502-816		1	1
30-93502-851		1	1
30-93502-852		1	1
30-93504-3		1	2
30-93505-19		1	2
30-93505-201		1 - 5	2
30-93505-27		1	2
30-93505-29		1	2
30-93505-3		1	1
30-93505-4		1	1
30-93505-7		1	2
30-93505-801		1	1
30-93505-802		1	1
30-93505-851		1	1
30-93505-852		1	1
30-93507-1		1 - 173	1
30-93507-13		1 - 178	1
30-93507-14		1	1
30-93507-2		1	1
30-93515-203		1 - 69	1
30-93515-204		1	1
30-93523-7		1 - 226	4
30-93525-7		1 - 234	4
30-93527-7		1 - 243	4
30-93531-7		1 - 231	1
30-93531-9		1 - 230	2
30-93533-7		1 - 311	1
30-93533-8		1	1
30-93534-7		1 - 235	4
30-93555-853		1	
		1	2
30-93555-855		1 - 128	1
30-93555-857		1	1
30-93555-867		1 - 143	1
30-93558-7		1 - 300	1
30-93560-7		1 - 294	1
30-93560-8		1	1
30-93561-7		1 - 308	1
30-93562-3		1	1
30-93563-7		1 - 309	1
30-93564-9		1 - 310	1
30-93565-1		1 - 248	1
30-93565-2		1	1
30-93565-3		1 - 249	1
30-93565-4		1	1
30-93566-15		1 - 254	1
30-93566-17		1 - 255	1
30-93566-201		1 - 256	1
30-93566-203		1 - 257	1
30-93567-1		1 - 220	1
30-93567-19		1 - 250	1
30-93567-2		1	1
30-93567-21		1 - 251	1
30-93567-23		1 - 252	1
30-93567-25		1 - 253	1
30-93570-201		1 - 277	1
30-93570-202		1 - 278	1
30-93571-7		1 - 272	4

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
30-93595-7		1 - 189	2
30-93596-7		1 - 190	2
20-92496-8		1 - 191	2
30-93597-7		1 - 184	2
30-93598-7		1 - 197	2
30-93802-201		1 - 261	2
30-93802-7		1 - 293	1
20-93400-1		1	7
30-94500-2		1	7
30-94500-3		1	1
30-94500-4		1	1
30-94502-1		1	1
30-94502-2		1	1
30-94502-5		1	1
30-94502-6		1	1
30-94502-801		1	1
30-94502-802		1	1
30-94520-1		1 - 198	1
30-94520-2		1	1
30-94520-5		1	1
30-94520-6		1	1
30-94520-7		1 - 203	1
30-94520-801		1	1
30-94520-802		1	1
30-94521-7		1 - 219	1
30-94522-7		1 - 215	1
30-94523-7		1 - 217	1
30-94524-7		1 - 216	1
30-94525-7		1 - 218	1
30-94526-7		1 - 209	1
30-94526-8		1	1
30-94528-201		1 - 206	1
30-94529-7		1 - 205	1
30-94530-7		1 - 207	1
30-94531-7		1 - 208	1
30-94532-10		1	1
30-94532-7		1	1
30-94532-8		1	1
30-94532-9		1	1
30-94540-201		1 - 55	1
30-94540-203		1	1
30-94540-207		1	2
30-94540-3		1	2
30-94540-851		1 - 54	1
30-94540-852		1	1
30-94540-9		1	2

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
30-94553-851		1	1
30-94553-852		1	1
30-94553-853		1	1
30-94553-854		1	1
30-94553-855		1	1
30-94553-856		1	1
30-94553-859		1	1
30-94553-860		1	1
30-94553-861		1	12
30-94553-862		1	11
30-94553-863		1	1
30-94553-864		1	1
30-94553-865		1	3
30-94553-866		1	3
30-94553-867		1	12
30-94553-868		1	11
30-94553-869		1	1
30-94553-870		1	1
30-94553-871		1	3
30-94553-872		1	3
30-94553-883		1	6
30-94553-884		1	6
30-94553-887		1	1
30-94553-888		1	1
30-94568-10		1	1
30-94568-11		1	1
30-94568-7		1	1
30-94568-8		1	1
30-94568-9		1	1
31-92330-801		1 - 57	1
31-92330-802		1	1
31-92505-9		1 - 86	2
31-92518-801		1 - 314	1
31-92518-802		1	1
31-92593-7		1 - 124	
		1	2
31-93302-1		1 - 56	2
5103-15		1 - 125	
		1	
		1 - 240	5
52NKTE048		1 - 244	
		1 - 223	5
52NKTE054		1 - 10	1
99-51507-022		1 - 181	2
99-53000-109		1 - 176	2

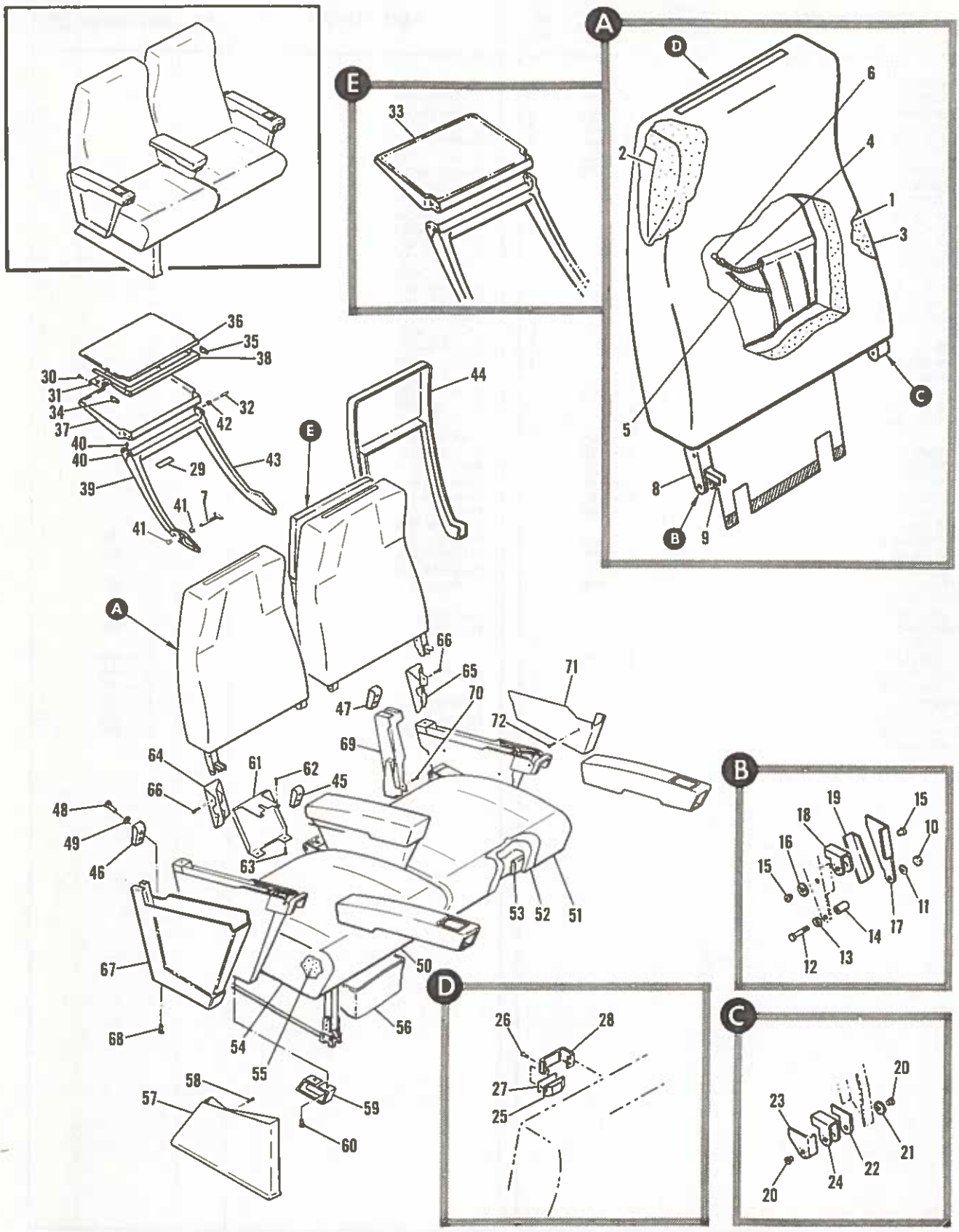

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -	22-90490-1	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	A			8
	22-90490-5	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	B			1
	22-93694-1	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	C			5
	30-94502-1	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	D			1
	30-94502-5	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	E			1
	30-94502-801	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	F			1
	30-94500-1	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	G			7
	30-94553-853	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	H			1
	30-94553-865	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	J			3
	30-94553-883	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	K			6
	30-94553-851	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	L			1
	30-94553-871	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	M			3
	30-94553-859	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	N			1
	30-94553-861	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	P			12
	30-94553-867	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH -V83115-	Q			12
	22-90490-3	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH ESCAPE HATCH -V83115-	R			1
	30-94500-3	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH ESCAPE HATCH -V83115-	S			1
	30-94553-869	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH ESCAPE HATCH -V83115-	T			1
	30-94553-887	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH ESCAPE HATCH -V83115-	U			1
	30-94553-855	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH ESCAPE HATCH -V83115-	V			1
	30-94553-863	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER LH ESCAPE HATCH -V83115-	W			1
	22-90490-2	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	X			8
	22-90490-6	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	Y			1
	22-93694-2	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	Z			5
	30-94502-2	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AA			1
	30-94502-6	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AB			1
	30-94502-802	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AC			1
	30-94500-2	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AD			7
	30-94553-854	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AE			1
	30-94553-866	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AF			3
	30-94553-884	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AG			6
	30-94553-852	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AH			1
	30-94553-872	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AJ			3
	30-94553-860	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AK			1
	30-94553-862	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AL			11
	30-94553-868	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH -V83115-	AM			11
	22-90490-4	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH ESCAPE HATCH -V83115-	AN			1
	30-94500-4	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH ESCAPE HATCH -V83115-	AP			1
	30-94553-870	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH ESCAPE HATCH -V83115-	AQ			1
	30-94553-888	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH ESCAPE HATCH -V83115-	AR			1
	30-94553-856	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH ESCAPE HATCH -V83115-	AS			1
	30-94553-864	SEAT ASSEMBLY, DOUBLE LUXURY PASSENGER RH ESCAPE HATCH -V83115-	AT			1
	22-90489-1	. BACK ASSEMBLY, INBD -V83115-	A-B, AN	R,X-	Y,	1
	22-90489-2	. BACK ASSEMBLY, OUTBD -V83115-	A-B, AN	R,X-	Y,	1
	30-93505-851	. BACK ASSEMBLY, INBD -V83115-	C,Z			1
	30-93505-852	. BACK ASSEMBLY, OUTBD -V83115-	C,Z			1
	30-93505-801	. BACK ASSEMBLY, INBD -V83115-	D-F,	AA-	AC	1
	30-93505-802	. BACK ASSEMBLY, OUTBD -V83115-	D-F,	AA-	AC	1
	30-93505-3	. BACK ASSEMBLY, INBD -V83115-	G,S,	AD,	AP	1
	30-93505-4	. BACK ASSEMBLY, OUTBD -V83115-	G,S,	AD,	AP	1
- 1	22-90489-7	. COVER, DOUBLE LUXURY SEAT BACK -V83115-	A-B, AN	R,X-	Y,	2

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	30-93505-27	. COVER, DOUBLE LUXURY SEAT BACK -V83115-	C,Z			2
	30-93505-29	. COVER, DOUBLE LUXURY SEAT BACK -V83115-	C,Z			2
	30-93505-7	. COVER, DOUBLE LUXURY SEAT BACK -V83115-	D-F,H-Q,AA-AC,AQ-AT	T-W,	AE-AM,	2
	30-93505-19	. COVER, DOUBLE LUXURY SEAT BACK -V83115-	G,S,AD,AP			2
- 2	22-92382-3	. PILLOW ASSEMBLY, PASSENGER SEAT HEADREST BONDED -V83115-	A-B,R,X-AE	Y,AN		2
- 3	22-92379	. CUSHION ASSEMBLY, SEAT BACK BONDED -V83115-	A-B,R,X-AE	Y,AN		2
	30-93504-3	. CUSHION ASSEMBLY, SEAT BACK BONDED -V83115-	C-Q,S-W,AP-AT	Z-AM		2
- 4	22-92596-11	. CORD, SEAT BACK ELASTIC -V83115-	D-G,S,AA-AP	AD,AP		2
- 5	30-93505-201	. CORD, SEAT BACK NYLON -V83115-	D-G,S,AA-AP	AD,AP		2
- 6	22-92360-9	. CLIP, ELASTIC CORD -V83115-	D-G,S,AA-AP	AD,AP		4
- 7	NAS1335A2C33	. PIN, QUICK DISCONNECT	A-AT			4
- 8	22-92560-803	. BACK ASSEMBLY, STRUCTURE INBD -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	22-92560-804	. BACK ASSEMBLY, STRUCTURE OUTBD -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	22-92560-801	. BACK ASSEMBLY, STRUCTURE INBD -V83115-	G,S,AD,AP			1
	22-92560-802	. BACK ASSEMBLY, STRUCTURE OUTBD -V83115-	G,S,AD,AP			1
- 9	22-94502-9	. . GUIDE, SEAT BACK -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		2
	22-94502-11	. . GUIDE, SEAT BACK -V83115-	G,S,AD,AP			2
- 10	52NKTE054	. . NUT, SELF-LOCKING CAP NYLON CONVAIR 96-37568-013 -V72962-	A-AT			1
- 11	AN960D516L	. . WASHER	A-AT			1
- 12	NAS1205-18	. . BOLT	A-AT			1
- 13	22-92568-17	. . WASHER, SEAT BACK -V83115-	A-AT			1
- 14	22-92352-7	. . SPACER, MECHANISM ATTACH BACK -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	22-92352-13	. . SPACER, MECHANISM ATTACH BACK -V83115-	G,S,AD,AP			1
- 15	NAS77-5-27	. . BUSHING	A-AT			2
- 16	22-92568-11	. . WASHER, SEAT BACK -V83115-	A-AT			1
- 17	22-92568-7	. . ANGLE, SEAT BACK INBD -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	30-94568-7	. . ANGLE, SEAT BACK INBD -V83115-	G,S,AD,AP			1
	22-92568-8	. . ANGLE, SEAT BACK OUTBD -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	30-94568-8	. . ANGLE, SEAT BACK OUTBD -V83115-	G,S,AD,AP			1
- 18	22-92568-13	. . CHANNEL, SEAT BACK -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	30-94568-11	. . CHANNEL, SEAT BACK -V83115-	G,S,AD,AP			1
- 19	22-92568-9	. . CLIP, SEAT BACK INBD -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	30-94568-9	. . CLIP, SEAT BACK INBD -V83115-	G,S,AD,AP			1
	22-92568-10	. . CLIP, SEAT BACK OUTBD -V83115-	A-F,H-R,AE-AN,AQ-AT	T-AC		1
	30-94568-10	. . CLIP, SEAT BACK OUTBD -V83115-	G,S,AD,AP			1
- 20	NAS77-5-27	. . BUSHING	A-AT			2
- 21	22-92568-11	. . WASHER, SEAT BACK -V83115-	A-AT			1
- 22	22-92569-201	. . SHIM, SEAT BACK -V83115-	A-AT			1
- 23	22-92568-15	. . ANGLE, SEAT BACK INBD -V83115-	A-AT			1
	22-92568-16	. . ANGLE, SEAT BACK OUTBD -V83115-	A-AT			1
- 24	22-92568-13	. . CHANNEL, SEAT BACK -V83115-	A-AT			1
- 25	H311-11	. . LATCH, FOOD TRAY -V83015- ATTACHING PARTS	A-AT			1
- 26	NAS623-2-3	. . SCREW	A-AT			2
- 27	22-92569-23	. . SHIM, SEAT BACK -V83115- ----x----	A-AT			2
- 28	22-92557-201	. . BRACKET, FOOD TRAY LATCH -V83115-	A-AT			1
- 29	22-92425-207	. PLACARD, LIFE VEST STOWAGE -V83115-	C,Z			2
	22-92425-201	. PLACARD, LIFE VEST STOWAGE -V83115-	G-J,S-T,AP-AQ	AD-AF		2
	22-92425-205	. PLACARD, LIFE VEST STOWAGE -V83115-	K,U,AG,AR			2
	22-92550-5	. TRAY INSTALLATION, FOOD -V83115-	A,C-E,H-U,W-X,Z-AE-AK,AM-AT	N,Q-R	AB, AN,AR,	2

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	22-92550-815	. TRAY INSTALLATION, FOOD -V83115-	G,S	AD,AP		2
- 30	AN507DD1032R6	. . SCREW	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			3
- 31	H311-17	. . LATCH, CONVAIR 95-51300-008 -V83015-	A,R,X,AN			1
	H311-21	. . LATCH, CONVAIR 95-51300-010 -V83015-	C-E,G-N,Q,S,U,W,Z-AB,AD-AK,AM,AP,AR,AT			1
- 32	22-92355	. . SCREW, TABLE TRAY PIVOT -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			4
- 33	22-92552-5	. . TABLE ASSEMBLY, FOOD TRAY -V83115-	A,C-E,H-N,Q-R,U,W-X,Z-AB,AE-AK,AM-AN,AR,AT			1
	22-92552-809	. . TABLE ASSEMBLY, FOOD TRAY -V83115-	G,S	AD,AP		1
- 34	22-92371-7	. . . SPACER, FOOD TRAY PIVOT LH -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			
- 35	22-92371-8	. . . SPACER, FOOD TRAY PIVOT RH -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			1
- 36	22-92554-27	. . . SHELL, FOOD TRAY BONDED -V83115-	A,C-E,H-N,Q-R,U,W-X,Z-AB,AE-AK,AM-AN,AR,AT			1
	22-92554-31	. . . SHELL, FOOD TRAY BONDED -V83115-	G,S	AD,AP		1
- 37	22-92554-17	. . . SHELL ASSEMBLY, FOOD TRAY BONDED -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			1
- 38	22-92555	. . . STRUCTURE ASSEMBLY, TRAY TABLE RIVETED -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			1
- 39	22-92551-1	. . SUPPORT ASSEMBLY, TRAY TABLE -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			1
- 40	AN565D1032H3	. . . SCREW	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			4
- 41	NAS77-5-38	. . . BUSHING	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			4
- 42	NAS75-3-016	. . . BUSHING	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			2
- 43	22-92551-7	. . . SUPPORT, -V83115-	A,C-E,G-N,Q-S,U,W-X,Z-AB,AD-AK,AM-AP,AR,AT			1
- 44	22-92361-1	. FAIRING ASSEMBLY, INBD FOOD TRAY DUMMY RIVETED -V83115-	B,F,P,T,V,Y,AC,AL,AQ,AS			1
- 45	22-92518-7	. STOP, FOOD TRAY -V83115-	A-N,Q-S,U,W-AK,AM-AP,AR,AT			2
- 46	22-92518-201	. STOP, FOOD TRAY -V83115-	A-N,Q-S,U,W-AK,AM-AP,AR,AT			1
- 47	22-92518-202	. STOP, FOOD TRAY -V83115-	A-N,Q-S,U,W-AK,AM-AP,AR,AT			1

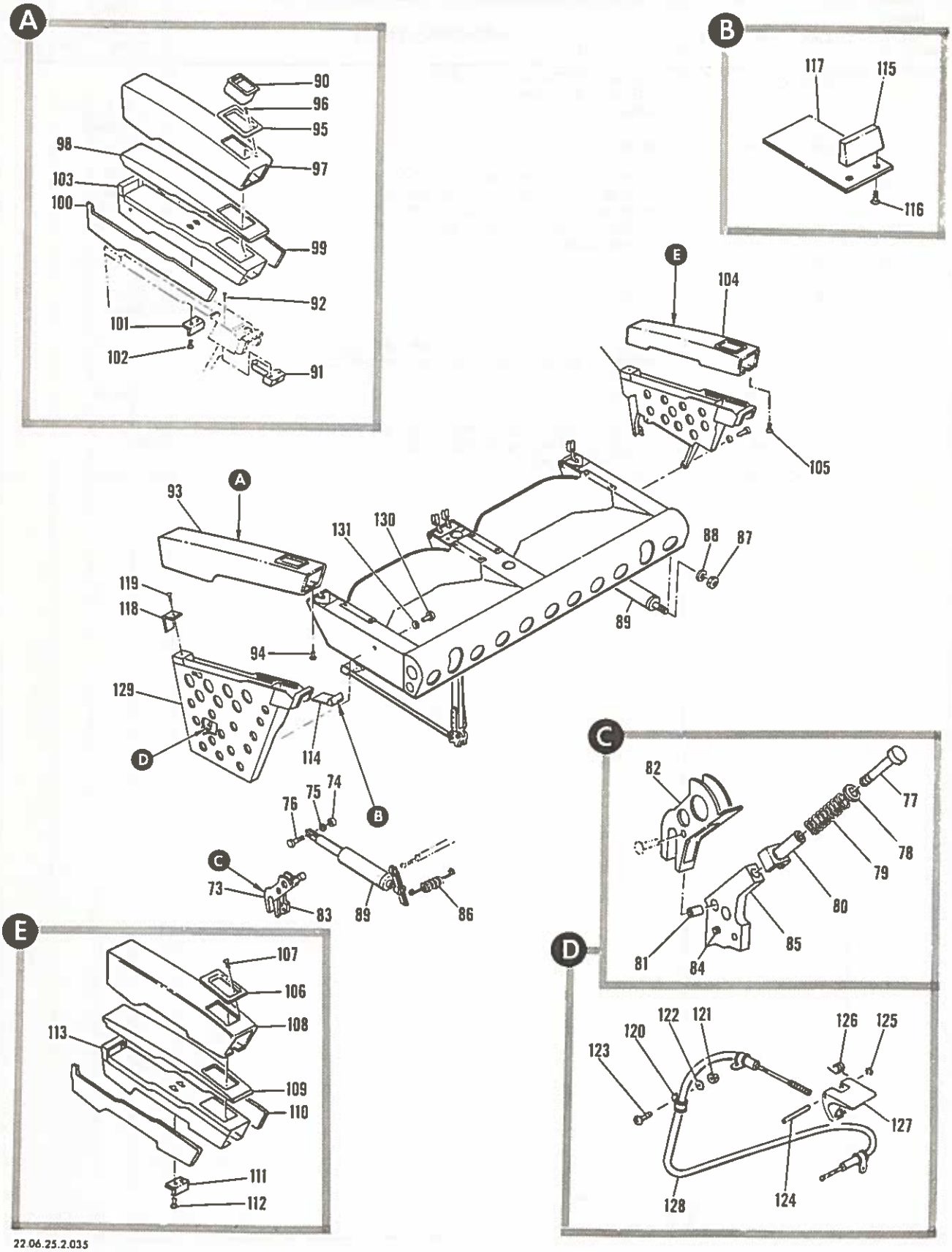
SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1		ATTACHING PARTS				
- 48	NAS1103-2	. BOLT	A-N,Q-S,U-AM-AP	W-AK,AR,	AT	8
- 49	AN960D10L	. WASHER	A-N,Q-S,U-AM-AP	W-AK,AR,	AT	8
		----x----				
	22-92339-801	. CUSHION ASSEMBLY, INBD LH BOTTOM -V83115-	A-B,	R		1
	22-92339-802	. CUSHION ASSEMBLY, INBD RH BOTTOM -V83115-	X-Y,	AN		1
	22-92339-803	. CUSHION ASSEMBLY, OUTBD LH BOTTOM -V83115-	A-B,	R		1
	22-92339-804	. CUSHION ASSEMBLY, OUTBD RH BOTTOM -V83115-	X-Y,	AN		1
	22-93698-807	. CUSHION ASSEMBLY, INBD AND OUTBD BOTTOM -V83115-	C-F, Z-AC, AQ-AT	H-Q, AE-	T-W, AM,	2
	30-94540-3	. CUSHION ASSEMBLY, INBD AND OUTBD BOTTOM -V83115-	G,S,	AD,	AP	2
- 50	22-92364-811	. COVER, INBD LH SEAT BOTTOM -V83115-	A-B,	R		1
	22-92364-812	. COVER, INBD RH SEAT BOTTOM -V83115-	X-Y,	AN		1
- 51	22-92364-813	. COVER OUTBD LH SEAT BOTTOM -V83115-	A-B,	R		1
	22-92364-814	. COVER, OUTBD RH SEAT BOTTOM -V83115-	X-Y,	AN		1
	22-93698-33	. COVER, INBD AND OUTBD SEAT BOTTOM -V83115-	C-F, Z-AC, AQ-AT	H-Q, AE-AM,	T-W,	2
	30-94540-9	. COVER, INBD AND OUTBD SEAT BOTTOM -V83115-	G,S,	AD,AP		2
	22-93698-9	. STRAP, BOTTOM COVER STITCHED -V83115-	C-F, Z-AC, AQ-AT	H-Q, AE-AM,	T-W,	2
	30-94540-207	. STRAP, BOTTOM COVER STITCHED -V83115-	G,S,	AD,AP		2
- 52	22-92558-11	. CUSHION, SEAT BOTTOM FOAM -V83115-	A-B, AE-AM,	H-R, AQ-AT	T-Y,	2
	22-92558-23	. CUSHION, SEAT BOTTOM FOAM -V83115-	C-F,	Z-AC		2
	22-92559-21	. CUSHION, SEAT BOTTOM FOAM -V83115-	G,S,	AD,AP		2
- 53	22-92559-201	. PAD, BOTTOM CUSHION FOAM -V83115-	A-AT			2
- 54	30-94540-851	. SOCK, BASE FRAME INBD COVER LH -V83115-	C-Q,	S-W		1
	30-94540-852	. SOCK, BASE FRAME INBD COVER RH -V83115-	Z-AM,	AP-AT		1
- 55	30-94540-201	. PAD, BASE FRAME INBD SOCK -V83115-	C-F, Z-AC, AQ-AT	H-Q, AE-AM,	T-W,	1
	30-94540-203	. PAD, BASE FRAME INBD SOCK -V83115-	G,S,	AD,AP		1
- 56	31-93302-1	. CONTAINER ASSEMBLY, LIFE VEST STITCHED -V83115-	A-C, X-Z, AN-AR	G-K, AD-AC,	R-U,	2
- 57	31-92330-801	. FAIRING ASSEMBLY, DOUBLE LUXURY SEAT LEG LH BONDED -V83115-	A-W			1
	31-92330-802	. FAIRING ASSEMBLY, DOUBLE LUXURY SEAT LEG RH BONDED -V83115-	X-AT			1
		ATTACHING PARTS				
- 58	AN526-1032R11	. SCREW	A-F, G-Q, AM,AP	R,X-S-W,	AC,AN AD-AT	5
	AN526-1032R12	. SCREW				5
		----x----				
- 59	22-92599	. STEP, DOUBLE LUXURY STEWARDESS -V83115-	N-Q,	W,AK-AM,AT		1
		ATTACHING PARTS				
- 60	AN509-416R15	. SCREW	N-Q,	W,AK-AM,AT		2
		----x----				
- 61	22-92331-7	. FAIRING, CENTER PIVOT REAR HINGE -V83115-	A-AT			1
		ATTACHING PARTS				
- 62	AN526-632R6	. SCREW	A-AT			2
- 63	AN526-1032R8	. SCREW	A-AT			2
		----x----				
- 64	22-92332-14	. FAIRING, INBD BACK LH -V83115-	A-F,	H-R,	T-W	1
	30-94532-7	. FAIRING, INBD BACK LH -V83115-	G,S			1
	22-92332-13	. FAIRING, INBD BACK RH -V83115-	X-AC, AQ-AT	AE-AM,		1
	30-94532-8	. FAIRING, INBD BACK RH -V83115-	AD,AP			1
- 65	22-92332-10	. FAIRING, OUTBD BACK LH -V83115-	A-F,	H-R,	T-W	1
	30-94532-9	. FAIRING, OUTBD BACK LH -V83115-	G,S			1
	22-92332-9	. FAIRING, OUTBD BACK RH -V83115-	X-AC, AQ-AT	AE-AM,		1

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	30-94532-10	. FAIRING, OUTBD BACK RH -V83115-	AD,AP			1
		ATTACHING PARTS				
- 66	AN526-632R6	. SCREW	A-F, AE-AN	H-R, AQ-AT	T-AC,	8
	AN526-1032R6	. SCREW	G,S,	AD,AP		4
		----x----				
- 67	22-92330-7	. FAIRING, INBD ARM SHELL LH -V83115-	A-G,	R-S		1
	22-92330-851	. FAIRING, INBD ARM SHELL LH -V83115-	H-Q,	T-W		1
	22-92330-8	. FAIRING, INBD ARM SHELL RH -V83115-	X-AD,	AN-AP		1
	22-92330-852	. FAIRING, INBD ARM SHELL RH -V83115-	AE-AN,	AQ-AT		1
		ATTACHING PARTS				
- 68	AN526-632R6	. SCREW	A-G, AN-AP	R-S,	X-AD,	AR
	AN526-832R8	. SCREW	H-Q, AM,	T-W, AQ-AT	AE-	AR
		----x----				
- 69	30-93515-203	. FAIRING, LUXURY SEAT OUTBD ARM LH -V83115-	A-Q			1
	30-93515-204	. FAIRING, LUXURY SEAT OUTBD ARM RH -V83115-	X-AM			1
		ATTACHING PARTS				
- 70	AN526-632R6	. SCREW	A-Q,	X-AM		2
		----x----				
- 71	22-92329-7	. FAIRING, LUXURY SEAT OUTBD ARM LH -V83115-	A-Q			1
	22-92329-8	. FAIRING, LUXURY SEAT OUTBD ARM RH -V83115-	X-AM			1
		ATTACHING PARTS				
- 72	AN526-632R4	. SCREW	A-Q,	X-AM		2
		----x----				

SEE IPC PAGE 30 FOR CODE EXPLANATION


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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 73	22-92587-803	. BREAKOVER ASSEMBLY, SEAT BACK -V83115-	A-F, T-V, AN,	H-M, X-AC, AQ-AS	R, AE-AJ,	2
	22-92587-801	. BREAKOVER ASSEMBLY, SEAT BACK -V83115-	D,S,	AD,AP		2
	22-92587-5	. BREAKOVER ASSEMBLY, SEAT BACK INBD -V83115-	N-Q,	W,AK-AM,AT		1
	22-92587-803	. BREAKOVER ASSEMBLY, SEAT BACK OUTBD -V83115-	N-Q,	W,AK-AM,AT		1
		ATTACHING PARTS				
- 74	AN364-1032	. NUT	A-B, AD,AN-AP	G,R-S,	X-Y,	2
	NAS1291-3	. NUT	C-F,	Z-AC		2
	NAS679A3	. NUT	H-Q, AQ-AT	T-W,	AE-AM,	2
- 75	AN960D10L	. WASHER	A-AT			2
- 76	NAS1103-9	. BOLT	A-AT			2
		----x----				
- 77	AN3-15A	. . BOLT	A-AT			1
- 78	AN960D416	. . WASHER	A-AT			1
- 79	22-92589-201	. . SPRING, BREAKOVER COMPRESSION -V83115-	A-M, AN-AS	R-V,	X-AJ,	1
	22-92589	. . SPRING, BREAKOVER COMPRESSION INBD -V83115-	N-Q,	W,AK-AM,AT		1
	22-92589-201	. . SPRING, BREAKOVER COMPRESSION OUTBD -V83115-	N-Q,	W,AK-AM,AT		1
- 80	22-92358-7	. . STOP, BREAKOVER FITTING -V83115-	A-AT			1
- 81	22-92352-9	. . SPACER, MECHANISM ATTACH BACK -V83115-	A-AT			1
- 82	22-94526-11	. . YOKE, BREAKOVER FITTING -V83115-	A-F, AE-AN,	H-R, AQ-AT	T-AC,	1
	22-94526-9	. . YOKE, BREAKOVER FITTING -V83115-	G,S,	AD,AP		1
- 83	22-92356	. . BLOCK ASSEMBLY, BREAKOVER -V83115-	A-F, AE-AN,	H-R, AQ-AT	T-AC,	1
	22-92356-851	. . BLOCK ASSEMBLY, BREAKOVER -V83115-	G,S,	AD,AP		1
- 84	22-92357	. . . PIN, BREAKOVER FITTING -V83115-	A-AT			1
- 85	22-92356-7	. . . BLOCK, BREAKOVER FITTING -V83115-	A-F, AE-AN,	H-R, AQ-AT	T-AC,	1
	22-92356-201	. . . BLOCK, BREAKOVER FITTING -V83115-	G,S,	AD,AP		1
- 86	31-92505-9	. SPRING, SEAT LOCK LEVER V83115-	C-Q, AP-AT	S-W,	Z-AM,	2
- 87	AN364-624	. NUT	A-AT			2
- 88	AN960D616	. WASHER	A-AT			AR
	22-94517-7	. SPRING, SEAT LOCK HELPER -V83115-	A-B,	R,X-Y,AN		4
	AN380-2-2	. PIN, COTTER	A-B,	R,X-Y,AN		2
	22-94516	. PIN, SEAT LOCK HELPER SPRING -V83115-	A-B,	R,X-Y,AN		2
- 89	L33-1035-1A	. LOCK, SEAT POSITIONER INBD AND OUTBD CONVAIR 96-93500-009 -V45402-	A-B,	R,X-Y,AN		2
	SL2600-1	. LOCK, SEAT POSITIONER INBD CONVAIR 96-93500-006 -V02953-	C-F, Z-AC, AQ-AT	H-Q, AE-AN,	T-W,	1
	SL2600-2	. LOCK, SEAT POSITIONER OUTBD CONVAIR 96-93500-007 -V02953-	C-F, Z-AC, AQ-AT	H-Q, AE-AN,	T-W,	1
	SL4500	. LOCK, SEAT POSITIONER INBD CONVAIR 96-93500-012 -V02953-	G,S,	AD,AP		1
	SL4500-1	. LOCK, SEAT POSITIONER OUTBD CONVAIR 96-93500-013 -V02953-	G,S,	AD,AP		1
- 90	22-92536	. ASH TRAY ASSEMBLY, INBD ARMCAP RIVETED -V83115-	A-B,	D-Y,AA-AT		1
	22-92536	. ASH TRAY ASSEMBLY, OUTBD ARMCAP RIVETED -V83115-	A-B, AA-AM	D-Q,	X-Y,	1
	22-94506-3	. ASH TRAY ASSEMBLY, INBD ARMCAP -V83115-	C,Z			1
	22-94506-4	. ASH TRAY ASSEMBLY, OUTBD ARMCAP -V83115-	C,Z			1
	22-92540-801	. . COVER AND ESCUTCHEON ASSEMBLY, RIVETED -V83115-	C,Z			1
	22-94507-1	. . RECEIVER ASSEMBLY, ASH TRAY INBD RIVETED -V83115-	C,Z			1
	22-94507-2	. . RECEIVER ASSEMBLY, ASH TRAY OUTBD RIVETED -V83115-	C,Z			1
- 91	22-92318-7	. FITTING, PLUG-IN FOOD TRAY INBD ARMCAP -V83115-	A-C, AN-AP,	E,G-H,	K-L,	1
	22-92318-7	. FITTING, PLUG-IN FOOD TRAY OUTBD ARMCAP -V83115-	A-C, AG-AH,	E,G-H,	K-L,	1

SEE IPC PAGE 30 FOR CODE EXPLANATION

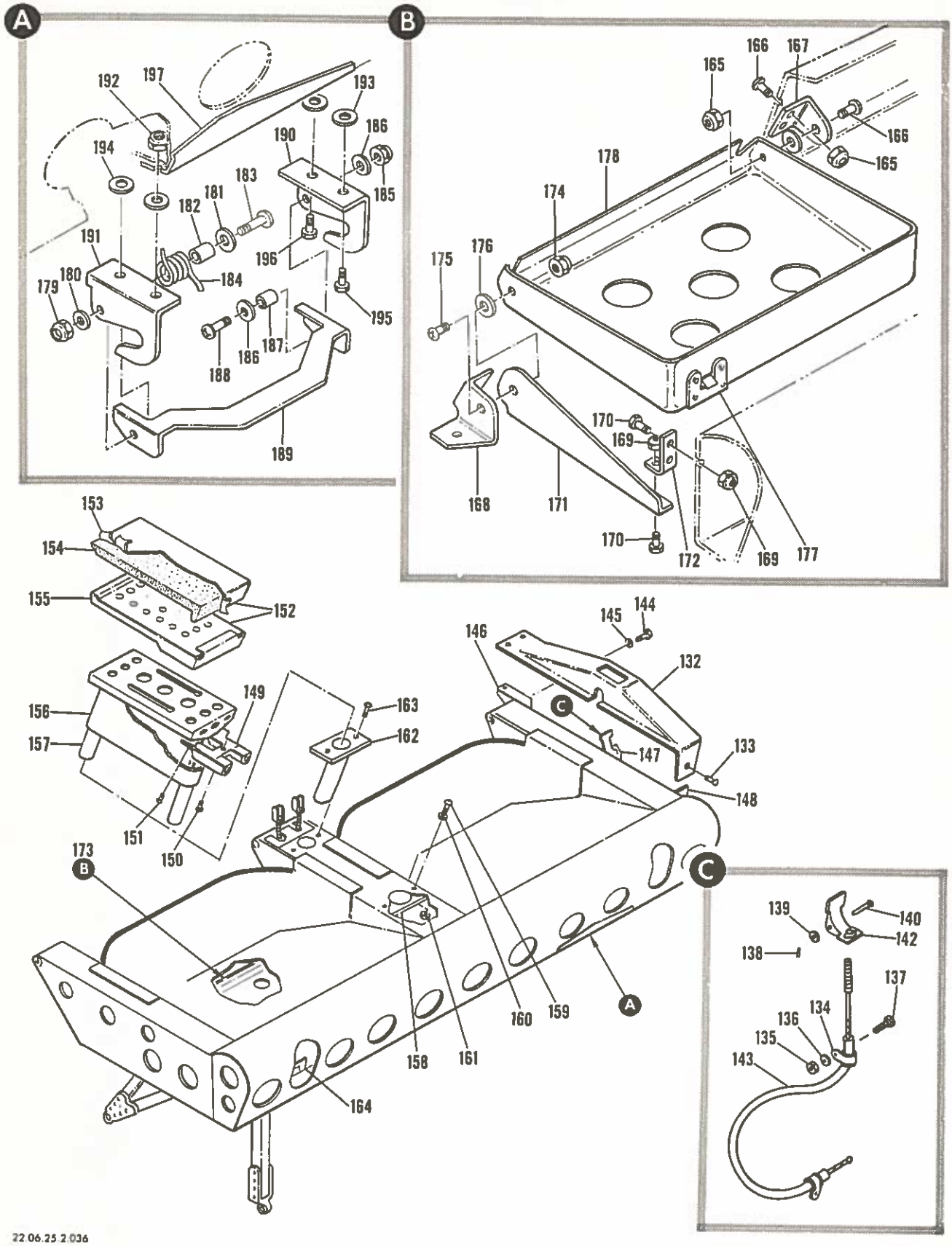
FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1		ATTACHING PARTS				
- 92	AN526-420R10	. SCREW, INBD	A-C,	E,G-H,K-L, N,R-S,U,X-Z,AB, AD-AE,AG-AH,AK, AN-AP,AR		3
	AN526-420R10	. SCREW, OUTBD	A-C,	E,G-H,K-L, N,X-Z,AB,AD-AE, AG-AH,AK		3
		----x----				
- 93	22-92324-1	. ARMCAP ASSEMBLY, INBD ARMREST LH -V83115-	A-B,	D-W		1
	22-92324-851	. ARMCAP ASSEMBLY, INBD ARMREST LH -V83115-	C			1
	22-92324-2	. ARMCAP ASSEMBLY, INBD ARMREST RH -V83115-	X-Y,	AA-AT		1
	22-92324-852	. ARMCAP ASSEMBLY, INBD ARMREST RH -V83115-	Z			1
		ATTACHING PARTS				
- 94	AN526-1032R6	. SCREW	A-AT			2
		----x----				
- 95	22-92539-1	. . ESCUTCHEON ASSEMBLY, ASH TRAY WELDED -V83115-	A-B,	D-Y,AA-AT		1
		ATTACHING PARTS				
- 96	AN509-632R4	. . SCREW	A-B,	D-Y,AA-AT		1
		----x----				
- 97	22-92368-1	. . COVER ASSEMBLY, INBD ARMCAP LH -V83115-	A-B,	D-W		1
	22-92368-201	. . COVER ASSEMBLY, INBD ARMCAP LH -V83115-	C			1
	22-92368-2	. . COVER ASSEMBLY, INBD ARMCAP RH -V83115-	X-Y,	AA-AT		1
	22-92368-202	. . COVER ASSEMBLY, INBD ARMCAP RH -V83115-	Z			1
- 98	22-92376-7	. . PAD, ARMCAP TOP -V83115-	A-B,	D-Y,AA-AT		1
	22-92376-201	. . PAD, ARMCAP TOP -V83115-	C,Z			1
- 99	22-92377-9	. . PAD, ARMCAP INBD SIDE -V83115-	A-AT			1
-100	22-92377-7	. . PAD, ARMCAP OUTBD SIDE -V83115-	A-AT			1
-101	22-92581	. . STOP, ASH TRAY COVER -V83115-	A-B,	D-Y,AA-AT		1
		ATTACHING PARTS				
-102	AN526-6R6	. . SCREW	A-B,	D-Y,AA-AT		2
		----x----				
-103	22-92325-1	. . STRUCTURE ASSEMBLY, INBD ARMCAP LH RIVETED -V83115-	A-B,	D-W		1
	22-92325-851	. . STRUCTURE ASSEMBLY, INBD ARMCAP LH RIVETED -V83115-				1
	22-92325-2	. . STRUCTURE ASSEMBLY, INBD ARMCAP RH RIVETED -V83115-	X-Y,	AA-AT		1
	22-92325-852	. . STRUCTURE ASSEMBLY, INBD ARMCAP RH RIVETED -V83115-	Z			1
-104	22-92326	. ARMCAP ASSEMBLY, OUTBD ARMREST -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
	22-92326-851	. ARMCAP ASSEMBLY, OUTBD ARMREST -V83115-	C,Z			1
		ATTACHING PARTS				
-105	AN526-1032R6	. SCREW	A-Q,	X-AM		2
		----x----				
-106	22-92539-1	. . ESCUTCHEON ASSEMBLY, ASH TRAY WELDED -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
		ATTACHING PARTS				
-107	AN509-632R4	. . SCREW	A-B,	D-Q,	X-Y, AA-AM	1
		----x----				
-108	22-92368-3	. . COVER ASSEMBLY, OUTBD ARMCAP -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
	22-92368-203	. . COVER ASSEMBLY, OUTBD ARMCAP -V83115-	C,Z			1
-109	22-92376-7	. . PAD, ARMCAP TOP -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
	22-92376-201	. . PAD, ARMCAP TOP -V83115-	C,Z			1
-110	22-92377-7	. . PAD, ARMCAP INBD AND OUTBD SIDE -V83115-	A-Q,	X-AM		2
-111	22-92581	. . STOP, ASH TRAY COVER -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
		ATTACHING PARTS				
-112	AN526-6R6	. . SCREW	A-B,	D-Q,	X-Y, AA-AM	2
		----x----				
-113	22-92327	. . STRUCTURE ASSEMBLY, OUTBD ARMCAP RIVETED -V83115-	A-B,	D-Q,	X-Y, AA-AM	1

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	22-92327-851	. . STRUCTURE ASSEMBLY, OUTBD ARMCAP RIVETED -V83115-	C,Z			1
-114	22-92538-851	. COVER ASSEMBLY, INBD ASH TRAY -V83115-	A-B,	D-Y,	AA-AT	1
-115	22-92538-203	. . KNOB, ASH TRAY COVER -V83115-	A-B,	D-Y,	AA-AT	1
		ATTACHING PARTS				
-116	AN507-440R3	. . SCREW	A-B,	D-Y,	AA-AT	2
		----x----				
-117	22-92538-201	. . PLATE, ASH TRAY COVER -V83115-	A-B,	D-Y,	AA-AT	1
	22-92538-851	. COVER ASSEMBLY, OUTBD ASH TRAY -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
	22-92538-203	. . KNOB, ASH TRAY COVER -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
		ATTACHING PARTS				
	AN507-440R3	. . SCREW	A-B,	D-Q,	X-Y, AA-AM	2
		----x----				
	22-92538-201	. . PLATE, ASH TRAY COVER -V83115-	A-B,	D-Q,	X-Y, AA-AM	1
-118	22-92315-13	. CAP ASSEMBLY, INBD SCUFF WELDED -V83115-	A-AT			1
	22-92315-13	. CAP ASSEMBLY, OUTBD SCUFF WELDED -V83115-	A-Q,	X-AM		1
		ATTACHING PARTS				
-119	AN507-1032R5	. SCREW, INBD	A-AT			1
	AN507-1032R5	. SCREW, OUTBD	A-Q,	X-AM		1
		----x----				
-120	MS21919DG4	. CLAMP, INBD ARMREST	A-AT			3
	MS21919DG4	. CLAMP, OUTBD ARMREST	A-Q,	X-AM		3
		ATTACHING PARTS				
-121	NAS679A08	. NUT, INBD	A-AT			3
	NAS679A08	. NUT, OUTBD	A-Q,	X-AM		3
-122	AN960D8	. WASHER, INBD	A-AT			3
	AN960D8	. WASHER, OUTBD	A-Q,	X-AM		3
-123	AN526-832R8	. SCREW, INBD	A-AT			3
	AN526-832R8	. SCREW, OUTBD	A-Q,	X-AM		3
		----x----				
-124	31-92593-7	. PIN, INBD ARMREST RECLINE LEVER -V83115-	A-AT			1
	31-92593-7	. PIN, OUTBD ARMREST RECLINE LEVER -V83115-	A-Q,	X-AM		1
-125	5103-15	. RING, INBD ARMREST RETAINING SNAP CONVAIR 97-61512-004 -V89462-	A-AT			1
	5103-15	. RING, OUTBD ARMREST RETAINING SNAP CONVAIR 97-61512-004 -V89462-	A-Q,	X-AM		1
-126	22-94504-201	. SPRING, INBD RECLINE LEVER -V83115-	A-AT			1
	22-94504-201	. SPRING, OUTBD RECLINE LEVER -V83115-	A-Q,	X-AM		1
-127	22-94503-207	. LEVER ASSEMBLY, SEAT RECLINE RIVETED INBD -V83115-	A-AT			1
	22-94503-207	. LEVER ASSEMBLY, SEAT RECLINE RIVETED OUTBD -V83115-	A-Q,	X-AM		1
	MS20392-1-9	. PIN, CLEVIS INBD	A-B,	R,X-Y,	AN	1
	MS20392-1-9	. PIN, CLEVIS OUTBD	A-B,	X-Y		1
	AN960C4L	. WASHER, INBD	A-B,	R,X-Y,	AN	1
	AN960C4L	. WASHER, OUTBD	A-B,	X-Y		1
	22-94510	. FORK, INBD RECLINE END -V83115-	A-B,	R,X-Y,	AN	1
	22-94510	. FORK, OUTBD RECLINE END -V83115-	A-B,	X-Y		1
-128	30-93555-855	. CABLE ASSEMBLY, INBD ARMREST SEAT LOCK SWAGED -V83115-	A-B,	R,X-Y,	AN	1
	30-93555-853	. CABLE ASSEMBLY, INBD ARMREST SEAT LOCK SWAGED -V83115-	C-Q,	S-W,Z-AM,	AP-AT	1
	30-93555-857	. CABLE ASSEMBLY, OUTBD ARMREST SEAT LOCK SWAGED -V83115-	A-B,	X-Y		1
	30-93555-853	. CABLE ASSEMBLY, OUTBD ARMREST SEAT LOCK SWAGED -V83115-	C-Q,	Z-AM		1
-129	22-92584-1	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	A-B,	D-G,	R-S	1
	22-92584-851	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	C			1
	22-92584-853	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	H-Q,	T-W		1
	22-92584-2	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	X-Y,	AA-AD,	AN-AP	1
	22-92584-852	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	Z			1
	22-92584-854	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	AE-AM,	AQ-AT		1
		ATTACHING PARTS				
-130	NAS1104-3	. BOLT, INBD ARMREST	A-AT			3
-131	AN960D416L	. WASHER, INBD ARMREST	A-AT			3
		----x----				
		SEE IPC PAGE 30 FOR CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	22-92586-1	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	A-B			1
	22-92586-853	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	C			1
	22-92586-3	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	D-Q			1
	22-92586-2	. STRUCTURE ASSEMBLY, OUTBD ARMREST RH RIVETED -V83115-	X-Y			1
	22-92586-854	. STRUCTURE ASSEMBLY, OUTBD ARMREST RH RIVETED -V83115-	Z			1
	22-92586-4	. STRUCTURE ASSEMBLY, OUTBD ARMREST RH RIVETED -V83115-	AA-AM			1
		ATTACHING PARTS				
	NAS1104-3	. BOLT, OUTBD ARMREST	A-Q,	X-AM		3
	AN960D416L	. WASHER, OUTBD ARMREST	A-Q,	X-AM		3
		----x----				

SEE IPC PAGE 30 FOR CODE EXPLANATION


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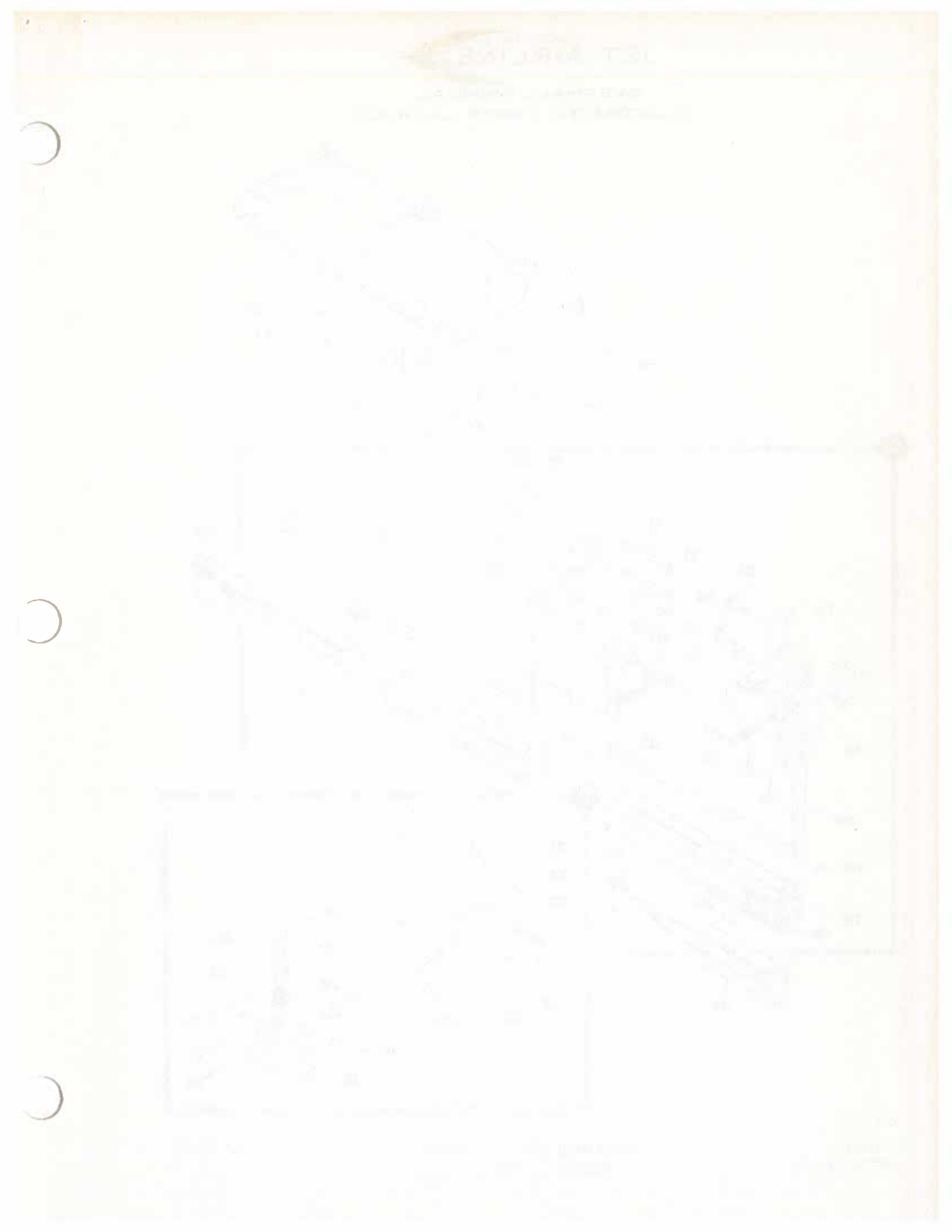
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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -132	22-92370-203	. FAIRING, OUTBD ESCAPE HATCH LH -V83115-	R-W			1
	22-92370-204	. FAIRING, OUTBD ESCAPE HATCH RH -V83115-	AN-AT			1
		ATTACHING PARTS				
-133	AN526-632R6	. SCREW	R-W,	AN-AT		5
		----x----				
-134	MS21919DG4	. CLAMP, OUTBD ESCAPE HATCH CABLE	RW,	AN-AT		2
		ATTACHING PARTS				
-135	NAS679A08	. NUT, OUTBD ESCAPE HATCH	R-W,	AN-AT		2
-136	AN960D8	. WASHER, OUTBD ESCAPE HATCH	R-W,	AN-AT		2
-137	AN526-832R8	. SCREW, OUTBD ESCAPE HATCH	R-W,	AN-AT		2
		----x----				
-138	AN380-2-1	. PIN, COTTER OUTBD ESCAPE HATCH	R-W,	AN-AT		1
-139	AN960-10L	. WASHER, OUTBD ESCAPE HATCH	R-W,	AN-AT		1
-140	MS20392-2-49	. PIN, CLEVIS OUTBD ESCAPE HATCH	R-W,	AN-AT		1
-141	22-94504-201	. SPRING, RECLINE LEVER ESCAPE HATCH -V83115-	R-W,	AN-AT		1
-142	22-94503-851	. LEVER ASSEMBLY, SEAT RECLINE OUTBD ESCAPE HATCH	R-W,	AN-AT		1
		RIVETED -V83115-				
	MS20392-1-9	. PIN, CLEVIS OUTBD ESCAPE HATCH	R,AN			1
	AN960C4L	. WASHER, OUTBD ESCAPE HATCH	R,AN			1
	22-94510	. FORK, RECLINE END OUTBD ESCAPE HATCH -V83115-	R,AN			1
-143	30-93555-867	. CABLE ASSEMBLY, SEAT LOCK OUTBD ESCAPE HATCH	R-W,	AN-AT		1
		SWAGED -V83115-				
-144	NAS1104-3	. BOLT, OUTBD ESCAPE HATCH	R-W,	AN-AT		1
-145	AN960D416L	. WASHER, OUTBD ESCAPE HATCH	R-W,	AN-AT		1
-146	22-92567-205	. CLIP, BASE FRAME OUTBD ESCAPE HATCH LH -V83115-	R-W			1
	22-92567-206	. CLIP, BASE FRAME OUTBD ESCAPE HATCH RH -V83115-	AN-AT			1
-147	22-92369-203	. PIVOT, RECLINE HANDLE OUTBD ESCAPE HATCH RIVETED	R-W,	AN-AT		1
		-V83115-				
-148	30-93502-45	. ANGLE, BASE FRAME OUTBD ESCAPE HATCH RIVETED	R-W,	AN-AT		1
		-V83115-				
-149	22-92318-11	. FITTING, PLUG-IN FOOD TRAY CENTER ARMCAP -V83115-	A-C,	E,G-H,K-L,		1
			N,R-S,U,X-Z,AB,			
			AD-AE,AG-AH,AK,			
			AN-AP,AR			
		ATTACHING PARTS				
-150	AN526-428R8	. SCREW	A-C,	E,G-H,K-L,		4
			N,R-S,U,X-Z,AB,			
			AD-AE,AG-AH,AK,			
			AN-AP,AR			
-151	AN526-428R12	. SCREW	A-C,	E,G-H,K-L,		1
			N,R-S,U,X-Z,AB,			
			AD-AE,AG-AH,AK,			
			AN-AP,AR			
		----x----				
-152	22-92375	. ARMCAP ASSEMBLY, CENTER ARMREST -V83115-	A-AT			1
-153	22-92366	. . COVER ASSEMBLY, CENTER ARMCAP -V83115-	A-AT			1
-154	22-92380-9	. . PAD, ARMCAP TOP -V83115-	A-AT			1
-155	22-92553	. . STRUCTURE ASSEMBLY, CENTER ARMCAP RIVETED -V83115-	A-AT			1
-156	22-92334	. FAIRING, CENTER ARMCAP BONDED -V83115-	A-AT			1
-157	22-92591-3	. ARMREST ASSEMBLY, CENTER RIVETED -V83115-	A-AT			1
-158	22-92532-11	. SOCKET, NYLON FRONT -V83115-	A-AT			1
		ATTACHING PARTS				
-159	AN526-1032R6	. SCREW	H-Q,	T-W,AE-AM,		4
			AQ-AT			
-160	AN960D10L	. WASHER	H-Q,	T-W,AE-AM,		4
			AQ-AT			
-161	NAS679A3	. NUT	H-Q,	T-W,AE-AM,		4
			AQ-AT			
		----x----				
-162	22-92533-7	. SOCKET, NYLON REAR -V83115-	A-AT			1
		ATTACHING PARTS				
-163	AN526-1032R7	. SCREW	A-AT			2
		----x----				
-164	22-92567-215	. PLATE, BASE FRAME STRIKER RIVETED -V83115-	N-Q,	W,AK-AM,AT		1
-165	NAS679A3	. NUT	N-Q,	W,AK-AM,AT		5

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -166	NAS623-3-2	. SCREW	N-Q,	W,AK-AM,AT		5
-167	22-92567-207	. CLIP, BASE FRAME LH -V83115-	N-Q,	W		1
-168	22-92567-209	. BRACKET, BASE FRAME LH -V83115-	N-Q,	W		1
	22-92567-208	. CLIP, BASE FRAME RH -V83115-	AK-AM,	AT		1
	22-92567-210	. BRACKET, BASE FRAME RH -V83115-	AK-AM,	AT		1
-169	NAS679A3	. NUT	N-Q,	W,AK-AM,AT		3
-170	NAS623-3-1	. SCREW	N-Q,	W,AK-AM,AT		3
-171	22-92567-211	. CHANNEL, BASE FRAME -V83115-	N-Q,	W,AK-AM,AT		1
-172	22-92567-213	. CLIP, BASE FRAME -V83115-	N-Q,	W,AK-AM,AT		1
-173	30-93507-1	. STOWAGE ASSEMBLY, BLANKET LH -V83115-	N-Q,	W		1
	30-93507-2	. STOWAGE ASSEMBLY, BLANKET RH -V83115-	AK-AM,	AT		1
		ATTACHING PARTS				
-174	NAS679A3	. NUT	N-Q,	W,AK-AM,AT		2
-175	NAS623-3-6	. SCREW	N-Q,	W,AK-AM,AT		2
		----x----				
-176	99-53000-109	. . WASHER, NONMETALLIC PHENOLIC	N-Q,	W,AK-AM,AT		2
-177	2268	. . LATCH, CONVAIR 95-51300-011 -V80477-	N-Q,	W,AK-AM,AT		1
-178	30-93507-13	. . PAN, BLANKET STOWAGE LH -V83115-	N-Q,	W		1
	30-93507-14	. . PAN, BLANKET STOWAGE RH -V83115-	AK-AM,	AT		1
-179	AN365-832	. NUT	G,K,	U,AD,AG,AR		2
-180	AN960D8	. WASHER	G,K,	U,AD,AG,AR		2
-181	99-51507-002	. WASHER, FLAT	G,K,	U,AD,AG,AR		2
-182	NAS43DD3-22	. SPACER	G,K,	U,AD,AG,AR		2
-183	NAS220-14	. SCREW	G,K,	U,AD,AG,AR		2
-184	30-93597-7	. SPRING, LEGREST LATCH -V83115-	G,K,	U,AD,AG,AR		2
-185	AN365-832	. NUT	G,K,	U,AD,AG,AR		2
-186	AN960D8	. WASHER	G,K,	U,AD,AG,AR		4
-187	NAS43DD3-9	. SPACER	G,K,	U,AD,AG,AR		2
-188	NAS220-10	. SCREW	G,K,	U,AD,AG,AR		2
-189	30-93595-7	. LATCH, LEGREST -V83115-	G,K,	U,AD,AG,AR		2
-190	30-93596-7	. HOOK, LEGREST OUTBD LH -V83115-	G,K,	U,AD,AG,AR		2
-191	30-93596-8	. HOOK, LEGREST INBD RH -V83115-	G,K,	U,AD,AG,AR		2
		ATTACHING PARTS				
-192	AN365-1032	. NUT	G,K,	U,AD,AG,AR		8
-193	AN960D10L	. WASHER	G,K,	U,AD,AG,AR		8
-194	AN960D10	. WASHER, AFT	G,K,	U,AD,AG,AR		4
-195	AN3-5A	. BOLT, FWD	G,K,	U,AD,AG,AR		4
-196	AN3-4A	. BOLT, AFT	G,K,	U,AD,AG,AR		4
		----x----				
-197	30-93598-7	. ANGLE, LEGREST MOUNTING RIVETED -V83115-	G,K,	U,AD,AG,AR		2

SEE IPC PAGE 30 FOR CODE EXPLANATION



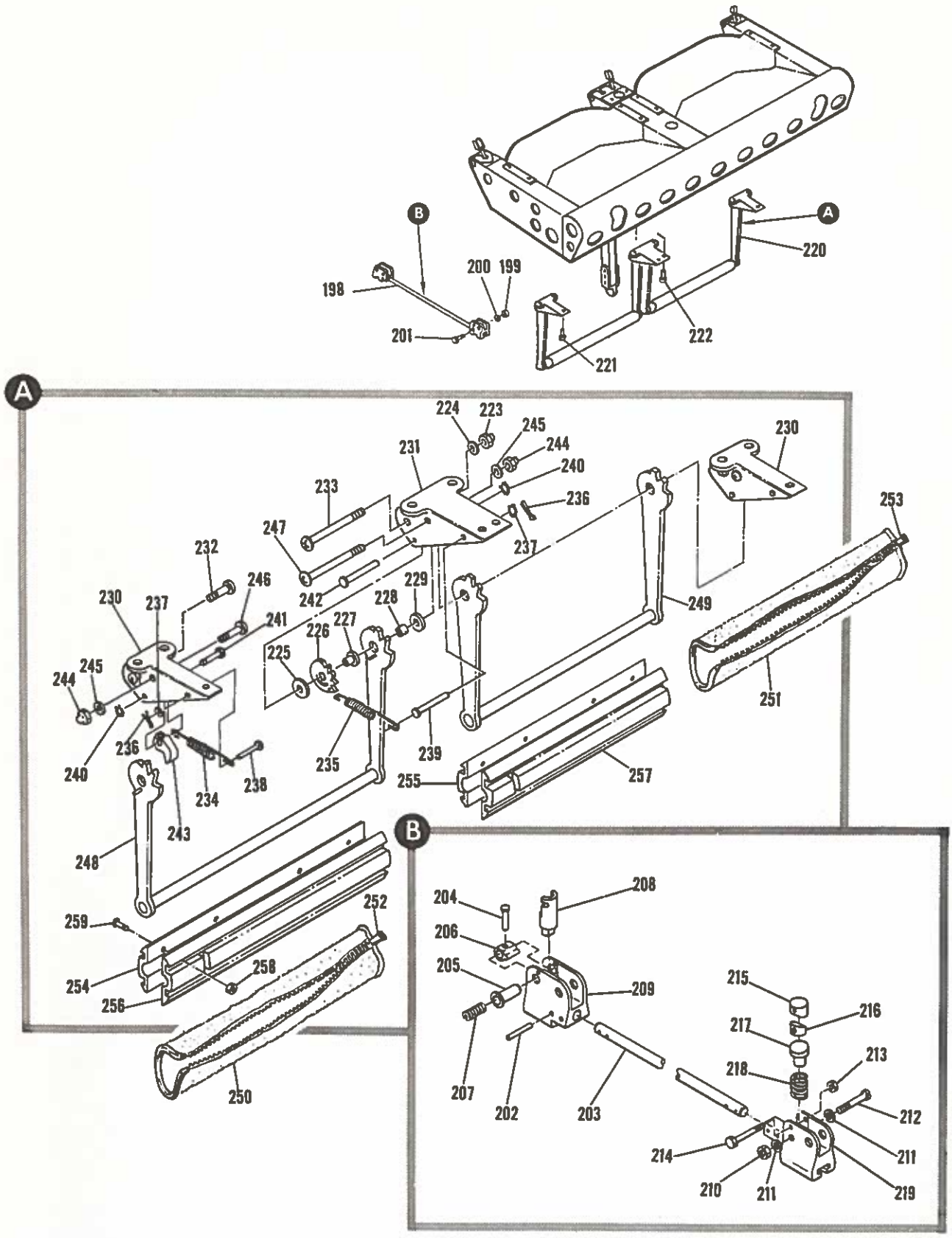
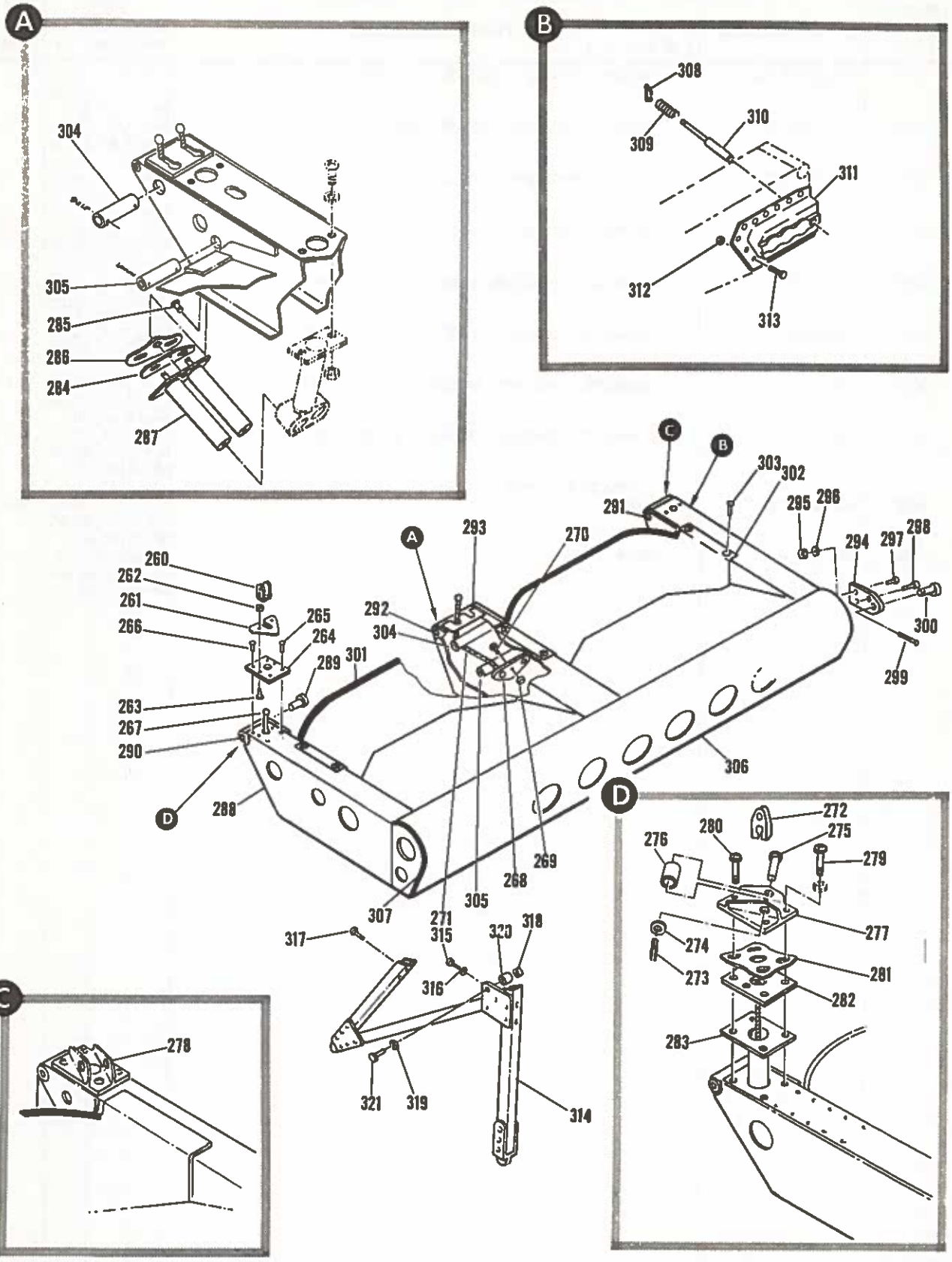

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -198	30-94520-1	. FOOT ASSEMBLY, PASSENGER SEAT LH -V83115-	A-W			1
	30-94520-2	. FOOT ASSEMBLY, PASSENGER SEAT RH -V83115-	X-AT			1
		ATTACHING PARTS				
-199	NAS1291-6	. NUT	A-AT			2
-200	AN960-616L	. WASHER	A-AT			2
-201	NAS623-6-13	. SCREW	A-AT			2
		----x----				
-202	NAS561P3-15	. . PIN, ROLL	A-AT			4
-203	30-94520-7	. . TUBE, -V83115-	A-AT			1
	30-94520-801	. . FITTING ASSEMBLY, AFT LH -V83115-	A-W			1
	30-94520-802	. . FITTING ASSEMBLY, AFT RH -V83115-	X-AT			1
	AN381-2-6	. . . PIN, COTTER	A-AT			1
-204	MS20392-1-19	. . . PIN, CLEVIS	A-AT			1
-205	30-94529-7	. . . PLUNGER, AFT FLOOR FITTING -V83115-	A-AT			1
-206	30-94528-201	. . . DRIVER, AFT FLOOR FITTING -V83115-	A-AT			1
-207	30-94530-7	. . . SPRING, AFT FLOOR FITTING COMPRESSION -V83115-	A-AT			1
-208	30-94531-7	. . . PIN, AFT FLOOR FITTING LOCK -V83115-	A-AT			1
-209	30-94526-7	. . . FITTING, AFT FLOOR LH -V83115-	A-W			1
	30-94526-8	. . . FITTING, AFT FLOOR RH -V83115-	X-AT			1
	30-94520-5	. . FITTING ASSEMBLY, FWD LH -V83115-	A-W			1
	30-94520-6	. . FITTING ASSEMBLY, FWD RH -V83115-	X-AT			1
	AN380-2-3	. . . PIN, COTTER	A-AT			1
-210	AN320C3	. . . NUT	A-AT			1
-211	AN960C10L	. . . WASHER	A-AT			2
-212	AN502-10-20	. . . SCREW	A-AT			1
-213	AN364-1032	. . . NUT	A-AT			1
-214	AN3C12A	. . . BOLT	A-AT			1
-215	30-94522-7	. . . BLOCK, FWD FLOOR FITTING -V83115-	A-AT			1
-216	30-94524-7	. . . WEDGE, FWD FLOOR FITTING -V83115-	A-AT			1
-217	30-94523-7	. . . PLUNGER, FWD FLOOR FITTING -V83115-	A-AT			1
-218	30-94525-7	. . . SPRING, FWD FLOOR FITTING COMPRESSION -V83115-	A-AT			1
-219	30-94521-7	. . . FITTING, FWD FLOOR -V83115-	A-AT			1
-220	30-93567-1	. FOOTREST ASSEMBLY, DOUBLE LUXURY SEAT LH -V83115-	A,G, U,W	K,N,	Q-S,	1
	30-93567-2	. FOOTREST ASSEMBLY, DOUBLE LUXURY SEAT RH -V83115-	X,AD, AP,AR	AG,AK,	AM- AT	1
		ATTACHING PARTS				
-221	NAS1103-5	. BOLT	A,R,	X,AN		8
-222	NAS1103-3	. BOLT	A,R,	X,AN		2
	NAS1203-5	. BOLT	G,S,	AD,AP		8
	NAS1203-3	. BOLT	G,S,	AD,AP		2
	NAS1203-5	. BOLT	K,N, AK,AM	Q,U,W,AG,	AR,AT	5
	NAS1203-6	. BOLT	K,N, AK,AM	Q,U,W,AG,	AR,AT	2
	NAS1203-4	. BOLT	K,N, AK,AM	Q,U,W,AG,	AR,AT	2
	NAS1203-3	. BOLT	K,N, AK,AM	Q,U,W,AG,	AR,AT	1
		----x----				
-223	52NKTE048	. . NUT, SELF-LOCKING CAP NYLON CONVAIR #9637568-004 -V72962-	A,G, U,W-X	K,N, AD,AG,AK AM-AP	Q-S, AR,AT	2
-224	AN960PD416L	. . WASHER	A,G, U,W-X	K,N, AD,AG,AK AM-AP	Q-S, AR,AT	2
-225	AN960-616	. . WASHER	A,G, U,W-X	K,N, AD,AG,AK AM-AP	Q-S, AR,AT	4
-226	30-93523-7	. . TRIPLATE, FOOTREST RATCHET -V83115-	A,G, U,W-X	K,N, AD,AG,AK AM AP	Q-S, AR,AT	4
-227	NAS77-4-20	. . BUSHING	A,G, U,W-X	K,N, AD,AG,AK AM-AP	Q-S, AR,AT	4
-228	NAS75-4-010	. . BUSHING	A,G, U,W-X	K,N, AD,AG,AK AM-AP	Q-S, AR,AT	4

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -229	22-92420-7	. . WASHER, FOOTREST NYLON -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	4
-230	30-93531-9	. . BRACKET, FOOTREST ATTACHMENT -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	2
-231	30-93531-7	. . BRACKET, FOOTREST ATTACHMENT -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	1
-232	NAS623-4-12	. . SCREW	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	2
-233	NAS623-4-24	. . SCREW	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	1
-234	30-93525-7	. . SPRING, EXTENSION -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	4
-235	30-93534-7	. . SPRING, EXTENSION -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	4
-236	AN380-1-2	. . PIN, COTTER	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	3
-237	AN960PD8	. . WASHER	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	3
-238	MS20392-1-25	. . PIN, CLEVIS	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	2
-239	MS20392-1-47	. . PIN, CLEVIS	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	1
-240	5103-15	. . RING, RETAINING SNAP CONVAIR 97-61512-004 -V89462-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	3
-241	22-92419-7	. . PIN, FOOTREST STOP -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	2
-242	22-92419-9	. . PIN, FOOTREST STOP -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	1
-243	30-93527-7	. . PAWL, FOOTREST RATCHET -V83115-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	4
		ATTACHING PARTS				
-244	52NKTE048	. . NUT, SELF-LOCKING CAP NYLON CONVAIR 96-37568-004 -V72962-	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	3
-245	AN960PD416L	. . WASHER	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	3
-246	NAS623-4-12	. . SCREW	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	2
-247	NAS623-4-24	. . SCREW	A,G,U,W-X,AM-AP	K,N,AD,AR	Q-S,AG,AK,AT	1
		----x----				
-248	30-93565-1	. . CROSSBAR ASSEMBLY, FOOTREST INBD LH WELDED -V83115-	A,G,U,W	K,N,X,AD,AM-AP	Q-S,AG,AK,AR,AT	1
	30-93565-2	. . CROSSBAR ASSEMBLY, FOOTREST INBD RH WELDED -V83115-				1
-249	30-93565-3	. . CROSSBAR ASSEMBLY, FOOTREST OUTBD LH WELDED -V83115-	A,G,U,W	K,N,X,AD,AM-AP	Q-S,AG,AK,AR,AT	1
	30-93565-4	. . CROSSBAR ASSEMBLY, FOOTREST OUTBD RH WELDED -V83115-				1
		SEE IPC PAGE 30 FOR CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -250	30-93567-19	. . CARPET, FOOTREST STITCHED -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-251	30-93567-21	. . CARPET, FOOTREST STITCHED -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-252	30-93567-23	. . ZIPPER, FOOTREST STITCHED -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-253	30-93567-25	. . ZIPPER, FOOTREST STITCHED -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-254	30-93566-15	. . CLAMSHELL, FOOTREST CROSSBAR UPPER -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-255	30-93566-17	. . CLAMSHELL, FOOTREST CROSSBAR UPPER -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-256	30-93566-201	. . CLAMSHELL, FOOTREST CROSSBAR LOWER -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
-257	30-93566-203	. . CLAMSHELL, FOOTREST CROSSBAR LOWER -V83115-	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	1
		ATTACHING PARTS				
-258	AN364-832NC2	. . NUT	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	16
-259	AN515-8-7	. . SCREW	A,G,	K,N,	Q-S, U,W-X,AD,AG,AK, AM-AP,AR,AT	16
		----x----				


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22.06.25.2.038

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -260	22-92395	. FITTING ASSEMBLY, CABLE BELT RIVETED -V83115-	A-M, AN-AS	R-V,	X-AJ,	4
-261	30-93802-201	. PLATE, PASSENGER SEAT BASE NYLON -V83115-	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	2
		ATTACHING PARTS				
-262	NAS679A3	. NUT	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	4
-263	AN509-10R8	. SCREW	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	4
		----x----				
-264	22-92547-209	. PLATE, ENERGY ABSORBER -V83115-	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	2
		ATTACHING PARTS				
-265	NAS1403-5	. SCREW	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	4
-266	NAS1403-6	. SCREW	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	4
		----x----				
-267	22-92374-851	. CABLE ASSEMBLY, SEAT BELT INBD AND OUTBD SWAGED -V83115-	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	2
-268	22-92547-203	. PLATE, ENERGY ABSORBER -V83115-	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	1
		ATTACHING PARTS				
-269	NAS679A3	. NUT	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	2
-270	AN526-1032R7	. SCREW	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	2
		----x----				
-271	22-92374-853	. CABLE ASSEMBLY, SEAT BELT CENTER SWAGED -V83115-	A-J, V,X-AF,AH-AJ, AN-AQ,AS	L-M,	R-T,	2
-272	30-93571-7	. YOKE, SEAT BELT BOLT ATTACH -V83115-	N-Q,W,AK-AM,AT			4
-273	AN380-3-2	. PIN, COTTER	K,N-Q,U,W,AG, AK-AM,AR,AT			2
-274	AN960D516	. WASHER	K,N-Q,U,W,AG, AK-AM,AR,AT			2
-275	MS20392-4-35	. PIN, CLEVIS	K,N-Q,U,W,AG, AK-AM,AR,AT			2
-276	22-92392-7	. ROLLER, ENERGY ABSORBER -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			2
-277	30-93570-201	. SUPPORT, ENERGY ABSORBER ROLLER INBD LH -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			1
-278	30-93570-202	. SUPPORT, ENERGY ABSORBER ROLLER OUTBD RH -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			1
		ATTACHING PARTS				
-279	NAS1403-5	. SCREW	K,N-Q,U,W,AG, AK-AM,AR,AT			4
-280	NAS1403-6	. SCREW	K,N-Q,U,W,AG, AK-AM,AR,AT			4
		----x----				
-281	22-92389-205	. SEAL, ENERGY ABSORBER DUST -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			2
-282	22-92547-209	. PLATE, ENERGY ABSORBER -V83115-	K,N-Q,U,W,AG AK-AM,AR,AT			2
-283	22-92543-853	. ABSORBER ASSEMBLY, INBD AND OUTBD WELDED -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			2

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -284	22-92547-203	. PLATE, ENERGY ABSORBER -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			1
		ATTACHING PARTS				
-285	AN526-1032R10	. SCREW	K,N-Q,U,W,AG, AK-AM,AR,AT			2
-286	22-92389-201	. SEAL, ENERGY ABSORBER DUST -V83115-	K,N-Q,U,W,AG AK-AM,AR,AT			1
		----x----				
-287	22-92542-851	. ABSORBER ASSEMBLY, CENTER WELDED -V83115-	K,N-Q,U,W,AG, AK-AM,AR,AT			1
-288	30-93502-805	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT LH -V83115-	A-B			1
	30-93502-815	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT LH -V83115-	C-F			1
	30-93502-801	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT LH -V83115-	G			1
	30-93502-851	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT LH -V83115-	H-Q,	T-W		1
	30-93502-807	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT LH -V83115-	R			1
	30-93502-803	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT LH -V83115-	S			1
	30-93502-806	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT RH -V83115-	X-Y			1
	30-93502-816	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT RH -V83115-	Z-AC			1
	30-93502-802	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT RH -V83115-	AD			1
	30-93502-852	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT RH -V83115-	AE-AM,AQ-AT			1
	30-93502-808	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT RH -V83115-	AN			1
	30-93502-804	. BASE ASSEMBLY, DOUBLE LUXURY PASSENGER SEAT RH -V83115-	AP			1
-289	NAS77-5-100	. . BUSHING	A-AT			4
-290	22-92519-201	. . PIVOT, SEAT BACK ATTACHMENT INBD -V83115-	A-AT			1
-291	22-92520-201	. . PIVOT, SEAT BACK ATTACHMENT OUTBD -V83115-	A-AT			1
-292	22-92519-203	. . PIVOT, SEAT BACK ATTACHMENT CENTER -V83115-	A-AT			1
-293	30-93802-7	. . STRIP, SEAT BASE NYLON RIVETED -V83115-	A-AT			1
-294	30-93560-7	. . RAIL, SIDE FITTING FWD LH -V83115-	A-W			1
	30-93560-8	. . RAIL, SIDE FITTING FWD RH -V83115-	X-AT			1
		ATTACHING PARTS				
-295	NAS679A3	. . NUT	A-AT			4
-296	AN960-10L	. . WASHER	A-AT			4
-297	NAS1203-5	. . BOLT	A-AT			2
-298	NAS1203-7	. . BOLT	A-AT			2
		----x----				
	AN380-1-1	. . PIN, COTTER	A-AT			1
-299	AN392-60	. . PIN, FLAT HEAD	A-AT			1
-300	30-93558-7	. . CAM, PASSENGER SEAT ANTI-RATTLE -V83115-	A-AT			1
-301	22-92353	. . BEAD, SEAT PAN RUBBER -V83115-	A-AT			2
-302	22-92516	. . PAN, PASSENGER SEAT -V83115-	A-AT			2
		ATTACHING PARTS				
-303	AN526-1032-5	. . SCREW	A-AT			8
		----x----				
	AN380-2-4	. . PIN, COTTER	A-AT			4
-304	22-92546-7	. . TUBE, ENERGY ABSORBER -V83115-	A-AT			1
-305	22-92546-11	. . TUBE, ENERGY ABSORBER -V83115-	A-AT			1
-306	22-92531-7	. . FAIRING, FRAME FRONT RIVETED LH -V83115-	A-W			1
	22-92531-8	. . FAIRING, FRAME FRONT RIVETED RH -V83115-	X-AT			1
-307	22-92353-7	. . BEAD, FAIRING RUBBER -V83115-	A-AT			1
	30-93562-3	. . PIN ASSEMBLY, PASSENGER SEAT AFT SIDE -V83115-	A-AT			1
-308	30-93561-7	. . . RING, SPLIT -V83115-	A-AT			1
-309	30-93563-7	. . . SPRING, COMPRESSION -V83115-	A-AT			1
-310	30-93564-9	. . . PIN, PASSENGER SEAT AFT SIDE -V83115-	A-AT			1

SEE IPC PAGE 30 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -311	30-93533-7	. . RAIL, SIDE FITTING AFT LH RIVETED -V83115-	A-W			1
	30-93533-8	. . RAIL, SIDE FITTING AFT RH RIVETED -V83115-	X-AT			1
-312	NAS1291-3	. . NUT	A-AT			3
-313	NAS1103-3	. . BOLT	A-AT			3
-314	31-92518-801	. . LEG ASSEMBLY, PASSENGER SEAT LH RIVETED -V83115-	A-W			1
	31-92518-802	. . LEG ASSEMBLY, PASSENGER SEAT RH RIVETED -V83115-	X-AT			1
		ATTACHING PARTS				
-315	NAS1104-3	. . BOLT	A-AT			2
-316	AN960D10L	. . WASHER	A-AT			2
-317	MS20004-4	. . BOLT	A-AT			2
-318	NAS679A4	. . NUT	A-AT			1
-319	AN960-416L	. . WASHER	A-AT			1
-320	NAS43DD4-48	. . SPACER	A-AT			1
-321	NAS1104-16	. . BOLT	A-AT			1
		----x----				

SEE IPC PAGE 30 FOR CODE EXPLANATION

EXPLANATION OF IPC USAGE CODE

CODE	ASSEMBLY P/N	TITLE	CUSTOMER MODEL NO.	CUSTOMER
A=	22-90490-1	LH Double Luxury	22(M)-4-1	CAT
B=	22-90490-5	LH Double Luxury	22(M)-4-1	CAT
C=	22-93694-1	LH Double Luxury	22(M)-22-1 thru -5	JAL
D=	30-94502-1	LH Double Luxury	22(M)-21-3	FAA
E=	30-94502-5	LH Double Luxury	22(M)-21-3	FAA
F=	30-94502-801	LH Double Luxury	22(M)-21-3	FAA
G=	30-94500-1	LH Double Luxury	30-6-3 thru -9	SWISSAIR
G=	30-94500-1	LH Double Luxury	30-6-1 thru -2	
H=	30-94553-853	LH Double Luxury	22(M)-3-5	CATHAY
H=	30-94553-853	LH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
J=	30-94553-865	LH Double Luxury	22(M)-3-5	CATHAY
J=	30-94553-865	LH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
K=	30-94553-883	LH Double Luxury	30-8-1 thru -3	VARIG
L=	30-94553-851	LH Double Luxury	22(M)-3-5	CATHAY
L=	30-94553-851	LH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
M=	30-94553-871	LH Double Luxury	22(M)-3-5	CATHAY
M=	30-94553-871	LH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
N=	30-94553-859	LH Double Luxury		
P=	30-94553-861	LH Double Luxury		
Q=	30-94553-867	LH Double Luxury		
R=	22-90490-3	LH Double Luxury	22(M)-4-1	CAT
S=	30-94500-3	LH Double Luxury	30-6-3 thru -9	SWISSAIR
S=	30-94500-3	LH Double Luxury	30-6-1 thru -2	
T=	30-94553-869	LH Double Luxury	22(M)-3-5	CATHAY
T=	30-94553-869	LH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
U=	30-94553-887	LH Double Luxury	30-8-1 thru -3	VARIG

(Continued on IPC Pages 31 and 32)

EXPLANATION OF IPC USAGE CODE (CONT)

CODE	ASSEMBLY P/N	TITLE	CUSTOMER MODEL NO.	CUSTOMER
V=	30-94553-855	LH Double Luxury	22(M)-3-5	CATHAY
V=	30-94553-855	LH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
W=	30-94553-863	LH Double Luxury		
X=	30-90490-2	RH Double Luxury	22(M)-4-1	CAT
Y=	22-90490-6	RH Double Luxury	22(M)-4-1	CAT
Z=	22-93694-2	RH Double Luxury	22(M)-22-1 thru -5	JAL
AA=	30-94502-2	RH Double Luxury	22(M)-21-3	FAA
AB=	30-94502-6	RH Double Luxury	22(M)-21-3	FAA
AC=	30-94502-802	RH Double Luxury	22(M)-21-3	FAA
AD=	30-94500-2	RH Double Luxury	30-6-3 thru -9	SWISSAIR
AD=	30-94500-2	RH Double Luxury	30-6-1 thru -2	
AE=	30-94553-854	RH Double Luxury	22(M)-3-5	CATHAY
AE=	30-94553-854	RH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
AF=	30-94553-866	RH Double Luxury	22(M)-3-5	CATHAY
AF=	30-94553-866	RH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
AG=	30-94553-884	RH Double Luxury	30-8-1 thru -3	VARIG
AH=	30-94553-852	RH Double Luxury	22(M)-3-5	CATHAY
AH=	30-94553-852	RH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
AJ=	30-94553-872	RH Double Luxury	22(M)-3-5	CATHAY
AJ=	30-94553-872	RH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
AK=	30-94553-860	RH Double Luxury		
AL=	30-94553-862	RH Double Luxury		
AM=	30-94553-868	RH Double Luxury		
AN=	22-90490-4	RH Double Luxury	22(M)-4-1	CAT
AP=	30-94500-4	RH Double Luxury	30-6-3 thru -9	SWISSAIR
AP=	30-94500-4	RH Double Luxury	30-6-1 thru -2	

(Continued on IPC Page 32)

EXPLANATION OF IPC USAGE CODE (CONT)

CODE	ASSEMBLY P/N	TITLE	CUSTOMER MODEL NO	CUSTOMER
AQ=	30-94553-870	RH Double Luxury	22(M)-3-5	CATHAY
AQ=	30-94553-870	RH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
AR=	30-94553-888	RH Double Luxury	30-8-1 thru -3	VARIG
AS=	30-94553-856	RH Double Luxury	22(M)-3-5	CATHAY
AS=	30-94553-856	RH Double Luxury	22(M)-3-1,-2,-3,-4,-6,-7	
AT=	30-94553-864	RH Double Luxury		

Chapter 25

PASSENGER SEAT ASSEMBLIES

(Convair Part No. 30-94551 Series)
(Convair Part No. 31-92503 Series)

1. Description and Operation

A. Physical Description

(1) The Convair 30-94551 series and 31-92503 series double coach, passenger seats are primarilly riveted sheet metal structures and consist of the major components of seat base assembly, back assemblies, leg assembly, side panel and armrest assemblies and food tray assemblies. The seats are mounted as units on two lock fittings at the outboard end at seat cushion level, and two floor attach fittings at the base of the single leg.

(2) Each seat provides foam-padded seat bottom and back cushions, foam-padded armrests, a pull-out food tray installation in the rear of the seat back, a lever, cable and lock installation for controlling recline and locking of the seat back, safety belt attach fittings, and ash trays with sliding or lid-type closures.

(3) Some seats not having passenger accommodations immediately aft contain dummy food trays in the rear of the seat back.

(4) Some seats, applicable on usage code M, N, Q and R, contain seat belt energy absorber assemblies.

(5) Some seats, applicable on usage code A, M and P, provide variable positioning, passenger footrest assemblies mounted on the aft underside of the seat base frame.

(6) Each functional food tray is provided with a recess at the rear of the seat back. Support arms, pivoted on the seat back pivot pin, carry a plastic tray pivoted on the upper end of the support arms. When not in use the tray is folded into the seat back and latched to a keeper in the seat structure. When the latch is pulled out, the tray folds down and the support arms pivot rearward to make the tray level. Stops on the tray pivot point control the tray angle, stops on the seat base structure control the limit of the support arm motion.

B. Leading Particulars

Size (tray closed)

Width	45 inches
Height	43 inches
Length	28 inches
Weight (approximate)	54 pounds
Angle of Recline	38 degrees
Recovery Time	2.0 seconds
Breakover	35 pounds steady pull

C. Operation

(1) The key operating feature of the seat is the reclining back and control. A lever in each side armrest of each seat is connected by a cable to a seat lock unit installed in the seat base structure.

(2) A breakover mechanism is mounted on the aft end of the seat lock unit, and the longer leg of the seat back engages a slot in the lower end of the breakover mechanism below the seat back pivot point. By this arrangement the seat lock controls movement of the seat back aft of normal. The breakover mechanism limits forward motion of the seat back to a normal forward seating position until a load of over 35 pounds is applied forward.

(3) The seat lock is a self-contained unit mounted under the base assembly. When the lever is lifted, the cable is pulled and the arm at the lock unit is actuated. The seat lock will release for back recline up to a maximum of 38 degrees. When reclined, the built-in spring provides recovery force for returning to normal position upon re-tripping the lever.

2. Disassembly

A. General

(1) The upholstery covers are fastened by Velcro tapes. The fixed section is a tape with small loops or eyes covering the surface; the section sewn to the cover is a tape of short stiff hooked fibers. When the cover section is pressed flat against the fixed section, the short fibers enter the eyes to form many hook-and-eye matings. This fastener is highly resistant to a pull in the plane of the joint, but separates readily when pulled vertically to the plane.

(2) The seat cushion foam lies loose in the pan and is effectively held by the cushion cover. All other foam is cemented in place and is likely to be damaged beyond use by removal. Handle cemented foam pieces with care to avoid pulling or stressing foam. Refer to paragraphs 5.B for procedure to remove or install foam.

B. Seat Cushions (See IPC Figure 1, Sheet 1)

(1) Remove seat cushion assembly by peeling Velcro from center of cover, on front underside of seat base, across front and around cover.

(2) Remove cover (48) from cushion (49).

(3) Remove pad (50) from base assembly fairing.

C. Seat Back and Food Tray Assembly (See IPC Figure 1, Sheet 1)

(1) Remove each seat back by removing two pins (5).

(2) At same time, remove food tray assembly or dummy food tray fairing (47) installed on usage code A, D-G, K, M, P, Q.

D. Food Tray Assembly (See IPC Figure 1, Sheet 1). Applicable on Usage Code A, D-G, K, M, P, Q.

(1) Remove latch (31) from table assembly (36) by removing the three screws (30).

(2) Remove table assembly (36) from support assembly (42) by removing four screws (32).

(3) Remove four screws (43), four bushings (44) and two bushings (45) from support assembly (42).

E. Fairings (See IPC Figure 1, Sheet 1)

(1) Remove center hinge fairing (57) from the aft side of the seat base assembly (217) by removing four screws (58).

(2) Remove back fairing (59) from the inboard leg of the inboard seat back by removing four screws (61).

(3) Remove back fairing (60) from the outboard leg of the outboard seat back by removing four screws (61).

F. Footrest Assembly (See IPC Figure 1, Sheet 3). Applicable on Usage Code A, M, P.

(1) Applicable on usage code A only. From the aft underside of the seat base assembly (217) remove footrest assembly (148) by removing four screws (149) and six screws (150).

(2) Applicable on usage code M, P only. From the aft underside of the seat base assembly (217) remove footrest assembly (148) by removing four bolts (149), six bolts (150) and two shims (151).

(3) Disassemble footrest assembly by removing two end brackets (159) and one center bracket (160).

(a) Remove nut (152), washer (153), screw (161), nut (173), washer (174), screw (175), retaining ring (169), pin (170), cotter pin (165), washer (166), and clevis pin (167) from outboard bracket (159).

(b) Remove screw (161), nut (173), washer (174), screw (175), retaining ring (169), pin (170), cotter pin (165), washer (166), and clevis pin (167) from inboard bracket (159).

(c) Remove nut (152), washer (153), screw (162), nut (173), washer (174), screw (176), retaining ring (169), pin (171), cotter pin (165), washer (166) and clevis pin (168) from center bracket (160).

(4) Remove two crossbar assemblies (177) with lower footrest parts attached from two brackets (159) and one bracket (160) by removing at the same time four washers (154), four triplates (155), four bushings (156), four bushings (157), four washers (158), four springs (163), four springs (164) and four pawls (172).

(5) Disassemble lower footrest parts by removing carpet (178) on each crossbar assembly (177). Remove upper and lower clamshells (180) and (181) from each crossbar assembly (177) by removing eight nuts (182) and eight screws (183).

G. Back Assembly (See IPC Figure 1, Sheet 1)

(1) Slip back cover (1) from seat back assembly From aft side of seat back assembly and while removing cover (1), disconnect literature pocket bungee cords from seat back structure assembly (6).

(2) Remove cord (4) from cover assembly (1).

(3) Remove cushion assembly (3) and pillow assembly (2) from seat back structure (6).

(4) From the longer leg of the seat back structure assembly (6) remove nut (8), washer (9), bolt (10), washer (11) and spacer (12).

(5) Remove bushing (13), bushing (14), washer (15), angle (16), channel (17) and clip (18).

(6) From the shorter leg of the seat back structure assembly (6) remove bushing (19), washer (20), shim (21), bushing (22), angle (23) and channel (24).

(7) From the upper aft side of the seat back structure assembly (6) remove latch (25) by removing two screws (26) and two shims (27).

(8) Remove latch bracket (28).

H. Inboard and Outboard Armrest Covers (See IPC Figure 1, Sheet 2)

(1) Remove ash tray assembly (86) from armrest cover assembly (87) by lifting up and forward past fully opened ash tray cover assembly (98)

Applicable on usage code D-E only. Remove ash tray assembly from armrest cover assembly by lifting straight up at ash tray escutcheon.

(2) Remove each armrest cover assembly (87) by removing two screws (88).

(3) Slide each armrest cover assembly forward until it stops or approximately one inch. Lift aft end of each armrest cover assembly with fingers to clear slots in armrest structure assemblies (113) and (114). Remove cover assemblies (87).

(4) Remove ash tray escutcheon (89) from armrest cover assembly (87) by removing one screw (90).

(5) Remove ash tray cover assembly (98) from each armrest structure assembly (113) and (114) by removing two screws (100) and knob (99). Slide ash tray cover plate (101) aft until it clears guides in armrest structure assembly and remove.

(6) Slip leather or fabric armrest cover (91) from armcap structure assembly (97) and remove armrest top pad (92), two outer armrest side pads (93) and two inner armrest side pads (94).

(7) Remove two armcap pins (96) and two washers (95) from aft underside of each armcap structure assembly (97).

I. Inboard and Outboard Scuff Cap (See IPC Figure 1, Sheet 2).

(1) Remove each scuff cap (102) by removing one screw (103).

J. Inboard and Outboard Armrest Fairings (See IPC Figure 1, Sheet 1)

(1) Remove inboard armrest fairing assembly (62) from armrest structure assembly (113) by removing screws (63) and (64).

(2) Remove outboard armrest fairings (65) and (66) from armrest structure assembly (114) by removing five screws (67).

K. Center Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Remove center armrest cover assembly (117) from center armrest assembly (125) by removing two screws (118). Slide cover assembly forward until it stops. Lift aft end of cover assembly with fingers to clear slots in armrest assembly 125.

(2) Slip armrest cover (119) from armcap structure assembly (124).

(3) Remove top pad (120) and two side pads (121) from armcap structure assembly (124).

(4) Remove two pins (123) and two washers (122) from underside of armcap structure assembly (124).

L. Recline Cable and Lever Assemblies (See IPC Figure 1, Sheet 2)

(1) From ash tray well of each armrest structure assembly (113) and (114), disconnect terminal end of cable assembly (112) from lever assembly (111).

(2) From each cable assembly (112) remove three clamps (104) by removing three nuts (105), three washers (106) and three screws (107) from within armrest assemblies (113) and (114) and aft side of bulkhead in base assembly (217).

(3) Remove retaining ring (109) from pin (108) in armrest structure and remove pin (108), spring (110) and lever assembly (111).

M. Inboard and Outboard Armrest Strcuture Assemblies (See IPC Figure 1, Sheet 2)

(1) Remove each armrest structure assembly (113) and (114) by removing three bolts (115) and three washers (116).

O. Stewardess Step (See IPC Figure 1, Sheet 1). Applicable on Usage Code M-N, Q-R.

(1) Remove stewardess step (55) and upper channel (56) by removing two screws (54) from seat base assembly (217).

P. Foot Assembly (See IPC Figure 1, Sheet 3).

(1) Remove leg fairing assembly (52) from seat leg assembly (249) by removing five screws (53).

(2) Remove foot assembly (126) from seat leg assembly (249) by removing two nuts (127), two washers (128) and two screws (129).

(3) Remove four pins (130) from fittings (137) and (147) and remove tube (131).

(4) From aft fitting (137), remove cotter pin, clevis pin (132), plunger (133), driver (134), spring (135) and pin (136).

(5) From forward fitting (147), remove cotter pin, nut (138), two washers (139), screw (140), nut (141), bolt (142), block (143), wedge (144), plunger (145) and spring (146).

Q. Breakover Assembly (See IPC Figure 1, Sheet 2).

(1) From the aft underside of seat base assembly (217), remove breakover assembly (68) from aft end of each seat lock (84) and (85) by removing nut (69), washer (70) and bolt (71).

(2) Disassembly breakover assembly (68) by removing bolt (72), washer (73), spring (74), stop (75), spacer (76), yoke (77) and pin (79) from block (80).

R. Seat Lock (See IPC Figure 1, Sheet 2)

(1) Remove spring (81).

(2) Disconnect cable assemblies and loosen nut at forward end of lock assembly. Remove seat locks (84) and (85) by lowering from between mountings on underside of seat base assembly (217).

S. Seat Belt Fittings (See IPC Figure 1, Sheet 4)

(1) Applicable on usage code A-L, P.

(a) Disconnect and remove four fittings (184) from two cable assemblies (191) and two cable assemblies (195).

(b) Remove one plate (185) from each aft side of seat base assembly (217) by removing two nuts (186) and two screws (187).

(c) Remove two plates (188) from center of seat base assembly (217) by removing four screws (189) and four screws (190).

(d) Remove one plate (192) from under seat base assembly beneath center armrest by removing two nuts (193) and two screws (194).

(2) Applicable on usage code M, N, Q, R.

(a) Disconnect and remove four seat belt attach yokes (196) from two absorber assemblies (206) and one center absorber assembly (210).

(b) Remove inboard energy absorber support (201) from seat base assembly (217) by removing two screws (203) and two screws (204).

(c) Remove outboard energy absorber support (202) from seat base assembly (217) by removing two screws (203) and two screws (204).

(d) Remove one dust seal (205) from under each energy absorber support (201) and (202).

(e) On each support (201) and (202), remove cotter pin (197), washer (198), roller (200) and clevis pin (199).

(f) Remove inboard and outboard absorber assemblies (206) by lifting up through base assembly (217).

(g) Remove center absorber assembly (210) from base assembly (217) by removing two screws (208). Remove energy absorber plate (207) and dust seal (209) from center absorber assembly (210).

NOTE: Socket assembly (211) must be removed concurrently. Refer to paragraph 2.T.(7).

T. Base Assembly (See IPC Figure 1, Sheet 4).

(1) Remove bead (230) from seat pan (231).

(2) Remove four bushings (218) from pivots (219), (220) and (221).

(3) Remove pivots (219), (220) and (221).

(4) Remove rail (223) by removing four nuts (224), four washers (225), two bolts (226) and two bolts (227). Remove cam (229) and pin (228).

(5) Remove two pans (231) by removing eight screws (232).

(6) Remove rear socket (215) by removing two screws (216).

(7) Remove forward socket (211) by removing four screws (212).

NOTE: Applicable on usage code A-L, P only. Remove socket (211) by removing four nuts (214), four washers (213) and four screws (212).

(8) Remove two energy absorber tubes (233) and (234) by removing four cotter pins.

(9) Remove bead (236) from fairing (235).

(10) Remove pin assembly. Remove ring (237) and spring (238) from pin (239).

(11) Remove three nuts (241) and three bolts (242) from rail (240).

(12) Remove rail (240).

(13) Remove four clips (243).

(14) Remove food tray stops (244), (245) and (246) by removing eight bolts (247) and eight washers (248).

(15) Remove leg assembly (249) by removing three bolts (250), two bolts (251) and two bolts (252).

CONVAIR
JET AIRLINER
OVERHAUL MANUAL

PASSENGER SEAT ASSEMBLIES - DOUBLE
(Convair Part Nos. 31-92503 and 30-94551 Series)

ATA NO. 25-2-32

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable To Models 22(M)-3, 22(M)-4, 22(M)-22, 30-5, 30-6, and 30-8

July 5/62

List of Effective Pages

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25-2-32	IPC 1	July 5/62	D
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3. Cleaning

A. General

(1) Clean upholstery covers installed over foam with soap and water as cleaning solvents are injurious to foam rubber.

(2) Use any standard commercial dry-cleaning procedure on a cover which has been removed.

CAUTION: REMOVE ALL RUBBER CORDS BEFORE APPLYING DRY-CLEANING SOLVENT TO COVER TO PREVENT DETERIORATION.

(3) Clean hard thermoplastic fairings with cleaning agent specified in paragraph 3.D.(10), or equivalent.

(4) Clean leather trim surfaces with soap and water or with cleaning agent specified in paragraph 3.D.(10).

(5) Clean carpet trim surfaces with cleaning agents specified in paragraphs 3.D.(1), (2), (3) and (4).

(6) Clean metal parts contaminated with oil or grease with cleaning solvent specified in paragraph 3.D.(9), or equivalent.

WARNING: USE CLEANING SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND AVOID CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(7) Clean foam rubber with soap and water.

(8) Clean metal adjacent to cemented Velcro tape with a water moistened cloth.

B. Types of Cleaning Agents

(1) No single type of cleaning agent is completely effective in the removal of all soiling; each product has its limitations. The instructions given on the product containers should be carefully followed to insure best results.

(2) Concentrated detergent preparations, commonly called upholstery shampoo, are effective in removing dry or water-borne soil. Recommended detergent preparations are specified in paragraphs 3.D.(1), (2), (3) and (4).

(3) Solvent type cleaning agents are effective in removal of oil-type soil or grease spots. Recommended solvent type cleaning agents are specified in paragraph 3.D.(5), (6) and (7).

Solvent impregnated powder specified in paragraph 3.D.(8) may be used instead of solvent cleaning agents.

C. Cleaning Procedure

(1) Vacuum upholstery thoroughly or brush with a medium stiff bristle upholstery or clothing brush. Do not pound or beat.

(2) Test material to be cleaned by first applying cleaning agent to a small inconspicuous area of material.

(3) Use solvent type cleaning agent or solvent impregnated powder to remove oil type soil or grease stains. Use cleaning materials sparingly, without saturating fabric, to avoid damage to foam. Apply cleaning agent with a clean soft cloth and avoid spreading any stains by working from the outer edges toward the center.

WARNING: WORK IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS. KEEP AWAY FROM OPEN FLAMES.

NOTE: Solvents should be evaporated rapidly from the fabric surface by directing an air stream from a vacuum cleaner or by fanning toward the material to avoid formation of rings.

(4) Mix upholstery shampoo as directed on container and apply to a small area (approximately one square foot) with a small brush. Liberal application will aid in loosening soil.

(5) Roll a clean turkish towel, or other absorbent cloth, into a cylindrical shape and wipe off detergent and soil. Rotate rolled towel frequently to present a clean section to upholstery fabric surface.

NOTE: Soil is absorbed or transferred to clean towel by this procedure. Vigorous rubbing may be required to obtain even soil removal and to avoid a blotching appearance after drying.

(6) Repeat procedures in steps 3.C.(4) and 3.C.(5) over entire surface of upholstery.

D. Materials

Use materials recommended or equivalents.

	MATERIAL	IDENTIFICATION	SOURCE
(1)	Upholstery cleaner	Foam Cleaner	E. I. Du Pont de Nemours & Co. (Inc.) Wilmington, Delaware
(2)	Upholstery cleaner	Glamorene	Glamorene Inc. 270 Park Ave. New York, New York
(3)	Upholstery cleaner	Mystic Foam	Mystic Foam Corp. Cleveland, Ohio
(4)	Upholstery cleaner	Duo-Dellay	Duo-Dellay Products Co. 4201 Puleshi Highway Baltimore, Maryland
(5)	Upholstery cleaner	Du Pont Dry Clean	E. I. Du Pont de Nemours & Co. (Inc.) Wilmington, Delaware
(6)	Upholstery cleaner	Carbone Instant Foam Lather	Carbone Corporation 30-50 Greenpoint Ave. Long Island City 1, N. Y.
(7)	Upholstery cleaner	Carbone Cleaning Fluid	Carbone Corporation 30-50 Greenpoint Ave. Long Island City 1, N. Y.
(8)	Upholstery cleaner	Powder-ene	Von Schroder Manufacturing Company Racine, Wisconsin
(9)	Cleaning solvent	Fed. Spec. P-S-661	Optional
(10)	Cleaning solvent	Sta-lube	Sta-lube 19510 S. Alameda St. Compton, California
(11)	Cement	EC-1300	Minnesota Mining and Mfg. Corporation St. Paul, Minnesota
(12)	Cement	T-161	American Latex Products Corporation Hawthorne, California

MATERIAL	IDENTIFICATION	SOURCE
(13) Abrasive cloth	No. 600 to 800 grade. Fed. Spec. P-C-451	Optional
(14) Crocus cloth	Fed. Spec. P-C-458	Optional
(15) Fiber strips	1-inch wide Velcro	Vel-Cro Sales Corp. 681 Fifth Avenue New York 22, New York
(16) Wrapping paper	Fed. Spec. UU-P-271	Optional
(17) Tape	Fed. Spec. JAN-P-127	Optional
(18) Abrasive cloth	No. 400 grade. Fed. Spec. P-C-451	Optional
(19) Paint	Vinyl Phenolic Moonstone Gray #169-A-56	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(20) Paint	Semi-Gloss Lacquer Tawny Beige #38-T-686	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(21) Paint	Semi-Gloss Lacquer Alpine Gray #38-H-692	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(22) Paint	Textured "Unichrome" Tawny Beige #6400-292	Metal and Thermite Corp. 100 Park Ave. New York 17, New York
(23) Paint	Semi-Gloss Lacquer Pearl White #38-W-536	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(24) Paint	Vinyl Phenolic Pearl White #169-W-515	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(25) Paint	Semi-Gloss Lacquer Baltic Blue #38-R-718	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California

MATERIAL	IDENTIFICATION	SOURCE
(26) Paint	Semi-Gloss Lacquer Pearl Gray #38-H-21	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(27) Paint	Textured "Unichrome" Pearl Gray #6400-249	Metal and Thermite Corp. 100 Park Ave. New York 17, New York
(28) Paint	Clear Lacquer #8780	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(29) Paint	Gold Pigmented Clear Lacquer #CC1401 Gold #8780	W. P. Fuller & Co. 300 Co. Mission St. San Francisco, California
(30) Paint	Vinyl Phenolic Milano Green #169-G-595	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(31) Paint	Semi-Gloss Lacquer Azure Blue	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(32) Paint	Vinyl Phenolic Pearl White #169-W-155	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(33) Paint	Semi-Gloss Lacquer Silver Blue #38-K-685	W. P. Fuller & Co. 300 So. Mission St. San Francisco, California
(34) Paint	Textured "Unichrome" Silver Blue #6400-248	Metal and Thermite Corp. 100 Park Ave. New York 17, New York

4. Inspection

A. General

Where doubt exists concerning serviceability of standard AN, NAS, MS parts, the part should be renewed.

B. Visual Inspection

Under strong light, preferably under magnification, visually inspect all parts as applicable, for scored or stripped threads, cracks, nicks, scratches, dents, corrosion and excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of parts.

C. Inspection Requirements

INDEX NO.	NOMENCLATURE	INSPECTION
-47, -52, -57, -59, -60, -62, -65, -66	Fairing	Dents, gouges, wear
-5, -79, -96, -108, -123, -136, -170, -171, -239	Pin	Wear, distortion
-25, -31	Latch	Wear, distortion
-36	Table Assembly	Wear, distortion
-13, -14, -19, -22 -44, -45, -156, -157 -218	Bushing	Wear
-46	Support	Wear, distortion
-74	Spring	Cracked, broken or deformed. Free length 1.00 inch
-75, -244, -245, -246	Stop	Cracks, wear
-76	Spacer	Wear, distortion
-77	Yoke	Cracks, wear
-80, -143	Block	Cracks, wear
-81	Spring	Cracked, broken or deformed. Free length 2.75 inches

INDEX NO.	NOMENCLATURE	INSPECTION
-84, -85	Lock	Operation
-111	Lever	Wear, cracks, broken nutplate
-112	Cable Assembly	Kinks, wear, broken wires, security of swaged ball, stripped terminal threads and damaged housing.
-110	Spring	Cracked, broken or deformed
-99	Knob	Wear, scratches
-101	Plate	Wear, scratches
-89	Escutcheon	Scratches
-1, -48, -87, -91 -117	Cover	Rips, tears, burns, cuts, wear
-50, -92, -93, -120, -121	Pad	Wear, tears, stiffness
-6, -41, -97, -113, -114, -124	Structure Assembly	Distortion, cracks, loosened nutplates and rivets.
-86	Ash Tray Assembly	Caking
-102	Cap Assembly	Wear, scratches
-125	Armrest Assembly	Wear, scratches loosened rivets
-131	Tube	Distortion, wear
-133, -145	Plunger	Wear, cracks
-134	Driver	Wear, cracks
-135, -146, -163, -164	Spring	Cracked, broken or deformed
-137, -147	Fitting	Distortion, wear, cracks

INDEX NO.	NOMENCLATURE	INSPECTION
-144	Wedge	Wear, cracks
-3, -49	Cushion	Wear, tears, damage, loss of resiliency
-217	Base Assembly	Distortion, cracks, loosened nutplates and rivets.
-2	Pillow	Wear, damage
-4	Cord	Wear, breaks
-18, -243	Clip	Cracks, breaks
-11, -15, -20	Washer	Cracks
-12, -37, -38	Spacer	Wear, distortion
-16, -23	Angle	Distortion, cracks
-17, -24, -56	Channel	Distortion, cracks
-28, -159, -160	Bracket	Distortion, cracks
-230, -236	Bead	Wear
-219, -220, -221	Pivot	Wear, cracks
-223, -240	Rail	Cracks, breaks, nicks, wear
-229	Cam	Distortion, cracks, nicks, wear
-231	Pan	Bends, cracks, breaks
-235	Fairing	Bends, cracks, loose rivets
-238	Spring	Cracked, broken or deformed. Free length 1.62 inch.
-249	Leg Assembly	Distortion, cracks, loosened nut plates and rivets.

INDEX NO.	NOMENCLATURE	INSPECTION
-233, -234	Tube	Bends, cracks, breaks
-169, -237	Ring	Cracks, breaks
-184	Fitting	Distortion, cracks
-196	Yoke	Distortion, cracks
-185, -188, -192, -207	Plate	Distortion, cracks, breaks
-191, -195	Cable Assembly	Kinks, wear, broken or frayed wire, security of swaged ball.
-200	Roller	Wear, breaks, cracks
-205, -209	Seal	Tears, rips
-201, -202	Support	Distortion, wear, cracks, breaks
-211, -215	Socket Assembly	Distortion, cracks, breaks
-206, -210	Absorber Assembly	Distortion, wear, cracks, breaks, broken or frayed wire, security of swaged ball.
-155	Triplate	Distortion, cracks, broken teeth
-172	Pawl	Distortion, cracks, breaks
-177	Crossbar Assembly	Distortion, cracks, broken teeth, sheared pin, bend tube.
-180, -181	Clamshell	Cracks, breaks
-178	Carpet	Tears, burns, stains, wear

5. Repair

A. General

(1) Minor nicks and scratches may be removed from aluminum alloy parts by polishing with oxide abrasive cloth specified in paragraph 3.D.(13), or equivalent. Clean all parts thoroughly after polishing.

(2) Minor nicks and scratches may be removed from non-critical steel parts by polishing with crocus cloth specified in paragraph 3.D.(14), or equivalent. Clean all parts thoroughly after polishing.

(3) Use standard shop practice for minor repair of sheet metal and riveted pieces.

(4) Components not satisfying inspection requirements must be repaired before seat is returned to service or storage. Repairs are listed in the following paragraphs. Components which require inspection and are not listed in these paragraphs should be renewed if damaged or worn.

B. Cemented Foam

(1) (See IPC Figure 1.) All foam pads except seat cushions (49) are cemented to the metal structure. The cemented joint normally is stronger than the foam itself, and usually the foam will be damaged beyond use during removal operations. Foam damaged during removal should not be reinstalled. Short sections of the cemented joint can be opened and re-cemented.

(2) To remove foam for renewal, use a sharp thin knife. Cut the foam close to the cemented joint while pulling foam away from the structure. Most of the foam should come off, leaving a thin layer of foam and cement on the metal. If a relatively even surface is obtained, new foam may be installed over this thin layer. If the layer is thick or uneven, strip down to bare metal before installing new foam. Use commercial grade acetone as solvent to soak layer before using a dull metal blade to scrape layer from metal.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

CAUTION: ACETONE CAUSES FOAM BREAKDOWN. DO NOT USE ACETONE IN MAKING MINOR REPAIRS. DO NOT REUSE FOAM SOAKED BY ACETONE.

(3) If foam is torn or loose, but is otherwise usable, cement the tear or the loose joint. Apply cement specified in paragraph 3.D.(11), or equivalent, to both sides of joint and allow to air dry until tacky. Press joint together and hold briefly.

NOTE: There is some local stiffening of foam at cemented joints. Avoid heavy or extensive cementing on seat foam surfaces or edges.

(4) (See IPC Figure 1, Sheet 2.) Instructions contained in paragraphs 5.B.(1), (2) and (3) apply to fairing cemented to the armrest structure assemblies. The fairings will possibly be damaged beyond use during removal. The metal must be scraped clean before a new fairing is cemented in place.

C. Fiber Strips (Velcro).

(1) Fixed strips of Velcro are cemented to the seat back and seat base structure. To remove a strip, soak with acetone.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(2) To install or repair a loosened strip, wipe metal surface clean and dry. Coat metal and Velcro with cement specified in paragraph 3.D.(11), or equivalent, and allow to air dry until tacky. Press joint together and hold briefly.

(3) Velcro strips are sewn to the cover material. If short sections of Velcro are loose, repair by sewing.

D. Paint

(1) Painted areas on the seat include the food tray shell assembly (40), the food tray support assembly (42), the dummy food tray fairing (47), the leg fairing (52), the rear center hinge fairing (57), the seat back fairings (59) and (60), and the arm fairings (62), (65) and (66).

(2) Nicks, scratches, gouges and scuff marks on these items mar the general appearance of the entire seat and should be restored to their original finish.

(3) Painted areas listed in paragraph 5.D.(1) damaged with shallow cuts and abrasions may be refinished as follows:

NOTE: Deep cuts or gouges to thermoplastic material cannot be satisfactorily repaired.

(a) Sand the damaged area lightly with abrasive cloth as specified in paragraph 3.D.(18).

NOTE: Extensive sanding of thermoplastic material removes the original "haircell" surface texture.

(b) Clean the sanded area with clean lint-free cloth moistened in acetone.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF THE VAPORS AND CONTACT WITH THE SKIN. KEEP AWAY FROM OPEN FLAMES.

(c) Paint the damaged areas with finishes as specified below.

NOTE: Thermoplastic components will contain either integral or surface color. Do not locally refinish or touch-up thermoplastic material containing integral color unless entire component is painted.

Applicable for Usage Code A-C

Paint the food tray shell assembly (40), the food tray support assembly (42), the dummy food tray fairing (47), the leg fairing (52), the rear center hinge fairing (57) and the arm fairings (62), (65) and (66) with one coat of lacquer as specified in paragraph 3.D.(29). Allow to air dry dust-free for two hours. Apply second coat of lacquer as specified in paragraph 3.D.(28).

Applicable for Usage Code D-E

Paint the leg fairing (52) with lacquer as specified in paragraph 3.D.(21).

Paint the food tray support assembly (42), the rear center hinge fairing (57) and the seat back fairings (59) and (60) with one coat of paint as specified in paragraph 3.D.(22).

Paint all other visible metal surface with one coat of paint as specified in paragraph 3.D.(20).

Applicable for Usage Code F-J

Paint leg fairing (52) with one coat of lacquer as specified in paragraph 3.D.(25).

Paint food tray support assembly (42) with paint as specified in paragraph 3.D.(27).

Paint the rear center hinge fairings (57), the seat back fairings (59) and (60) and all other visible painted surfaces with lacquer as specified in paragraph 3.D.(26).

Applicable for Usage Code K-L

Paint the food tray shell (40), the dummy food tray fairing (47) and the leg fairing (52) with lacquer as specified in paragraph 3.D.(31).

Paint the rear center hinge fairing (57), the seat back fairings (59) and (60) and all visible painted surfaces with lacquer as specified in paragraph 3.D.(23).

Paint the food tray support assembly (42) with paint as specified in paragraph 3.D.(32).

Applicable for Usage Code M-N

Paint the food tray support assembly (42) with paint as specified in paragraph 3.D.(32).

Paint the rear center hinge fairing (57), the seat back fairings (59) and (60) and all other visible painted surfaces with lacquer as specified in paragraph 3.D.(23).

Applicable for Usage Code Q-R

Paint the food tray shell assembly (40), the dummy food tray fairing (47), the food tray support assembly (42), the rear center hinge fairings (59) and (60), the arm fairings (62), (65) and (66) and all visible painted metal surfaces with lacquer as specified in paragraph 3.D.(19).

Applicable for Usage Code P

Paint the food tray support assembly (42) and all visible painted metal surfaces with paint as specified in paragraph 3.D.(30).

6. Assembly

A. Base Assembly (See IPC Figure 1, Sheet 4)

(1) Install leg assembly (249) using three bolts (250), two bolts (251) and two bolts (252).

(2) Install food tray stops (244), (245) and (246) using eight bolts (247) and eight washers (248).

(3) Install four clips (243).

(4) Install rail (240).

(5) Install three bolts (242) and three nuts (241) in rail (240).

(6) Install spring (238) and ring (237) on pin (239). Install pin assembly through base assembly and rail (240).

(7) Install bead (236) on fairing (235).

(8) Install two energy absorber tubes (233) and (234) in base assembly (217) using four cotter pins.

(9) Install forward socket (211) using four screws (212).

NOTE: Applicable on usage code A-L, P only. Install forward socket (211) using four screws (212), four washers (213) and four nuts (214).

(10) Install rear socket (215) using two screws (216).

(11) Install two pans (231) using eight screws (232).

(12) Install rail (223) using two bolts (226), two bolts (227), four washers (225) and four nuts (224). Install cam (229) and pin (228) in rail (223).

(13) Install pivots (219), (220) and (221).

(14) Install four bushings (218) in pivots (219), (220) and (221).

(15) Install bead (230) on seat pan (231) using cement as specified in paragraph 3.D.(12).

(16) Applicable on usage code A-L, P. Install two cable assemblies (191) and two cable assemblies (195) in base assembly.

B. Seat Belt Fittings (See IPC Figure 1, Sheet 4)

(1) Applicable on usage code A-L, P.

(a) Install plate (192) under seat base assembly beneath center armrest using two screws (194) and two nuts (193).

(b) Install two plates (188) on seat base assembly using four screws (189) and four screws (190).

(c) Install plate (185) on each side of seat base assembly using two screws (187) and two nuts (186).

(d) Install four fittings (184) on the two cable assemblies (191) and two cable assemblies (195).

(2) Applicable on usage code M, N, Q, R.

(a) Position dust seal (209) and energy absorber plate (207) on center absorber assembly (210). Install center absorber assembly in seat base assembly under center armrest bay using two screws (208). Route ball ends of attached cables over forward energy absorber tube (234) and under aft energy absorber tube (233). Pull ball ends of cables up through slotted openings in seat base assembly.

(b) Insert inboard and outboard absorber assemblies (206) in aft openings in base frame assembly.

(c) Install roller (200), washer (198), clevis pin (199) and cotter pin (197) on each support (201) and (202).

(d) Position one dust seal (205) over inboard and outboard absorber assemblies (206). Line up all fastener holes.

(e) Position outboard energy absorber support (202) over dust seal (205) on outboard absorber assembly (206). Install two screws (203) and two screws (204).

(f) Position inboard energy absorber support (201) over dust seal (205) on inboard absorber assembly (206). Install two screws (203) and two screws (204).

(g) Install four seal belt attach yokes (196) over ball ends of two absorber assemblies (206) and one center absorber assembly (210).

C. Seat Lock (See IPC Figure 1, Sheet 2)

(1) Position seat locks (84) and (85) in place in lock mounts under seat base assembly (217). Tighten nut on forward end of each seat lock against seat frame lock mounts.

(2) Install spring (81).

(3) Connect cable assembly (112).

D. Breakover Assembly (See IPC Figure 1, Sheet 2).

(1) Assemble breakover assembly by installing pin (79), yoke (77), spacer (76), stop (75), spring (74), washer (73) and bolt (72) in block (80).

(2) Install breakover assembly on lock (84) and (85) at the aft underside of seat base assembly (217) using bolt (71), washer (70) and nut (69).

E. Foot Assembly (See IPC Figure 1, Sheet 3)

(1) Install spring (146), plunger (145), wedge (144), block (143), bolt (142), nut (141), screw (140), two washers (139), nut (138) and cotter pin in forward fitting (147).

(2) Install pin (136), spring (135), driver (134), plunger (133), clevis pin (132) and cotter pin in aft fitting (137).

(3) Insert tube (131) into openings in both fittings (137) and (147). Install four pins (130).

(4) Install foot assembly (126) on seat leg assembly (249) using two screws (129), two washers (128) and two nuts (127).

(5) Install leg fairing assembly (52) using five screws (53).

F. Stewardess Step (See IPC Figure 1, Sheet 1). Applicable on Usage Code M, N, Q, R.

(1) Install stewardess step (55) and upper channel (56) on seat base assembly using two screws (54).

G. Inboard and Outboard Armrest Structure Assemblies (See IPC Figure 1, Sheet 2).

(1) Install each armrest structure assembly (113) and (114) on seat base assembly using three bolts (115) and three washers (116).

H. Recline Cable and Lever Assemblies (See IPC Figure 1, Sheet 2)

(1) Install lever assembly (111) in armrest structure using spring (110), pin (108) and retaining ring (109).

(2) Install cable assembly (112) in armrest structure assemblies (113) and (114) using three clamps (104), three nuts (105), three washers (106) and three screws (107).

(3) Connect cable assembly (112) to lever assembly (111).

I. Center Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Install two washers (122) and two pins (123) on underside of armcap structure assembly (124).

(2) Place top pad (120) and two side pads (121) on armcap structure assembly (124) and install armrest cover (119).

(3) Position center armrest cover assembly (117) on center armrest assembly (125) to engage cover assembly pins in armrest assembly slots. Push down cover assembly and slide aft.

(4) Install center armrest cover assembly (117) on center armrest assembly (125) with two screws (118).

J. Inboard and Outboard Armrest Fairings (See IPC Figure 1, Sheet 1)

(1) Install outboard armrest fairings (65) and (66) on armrest structure assembly (114) using five screws (67).

(2) Install inboard armrest fairing (62) on armrest structure assembly (113) using screws (63) and (64).

K. Inboard and Outboard Scuff Cap (See IPC Figure 1, Sheet 2)

(1) Install each scuff cap (102) using screw (103).

L. Inboard and Outboard Armrest Covers (See IPC Figure 1, Sheet 2)

(1) Install two washers (95) and two pins (96) on aft underside of each armcap structure assembly (97).

(2) Place top pad (92), two inner armrest side pads (94) and two outer side pads (93) on each armcap structure assembly (97) and install armrest cover (91).

(3) Install ash tray cover plate (101) in guides in armrest structure assemblies (113) and (114). Install knob (99) on cover plate (101) using two screws (100).

(4) Install ash tray escutcheon (89) in each armrest cover assembly (87) using screw (90).

(5) Position each armrest cover assembly (87) on armrest structure assemblies (113) and (114) to engage armrest cover pins in armrest structure slots. Push down and slide aft.

(6) Install ash tray assembly (86) in each armrest cover assembly (87).

(7) Applicable on usage code D-E only. Install ash tray assembly (86) in each armrest cover assembly (87) by inserting past open ash tray cover assembly.

M. Back Assembly (See IPC Figure 1, Sheet 1)

(1) Install latch bracket (28).

(2) Install latch (25) in seat back structure assembly using two shims (27) and two screws (26).

(3) Install channel (24), angle (23), bushing (22), shim (21), washer (20) and bushing (19) on shorter leg of seat back structure assembly (6).

(4) Install clip (18), channel (17), angle (16), washer (15), bushing (14) and bushing (13).

(5) Install spacer (12), washer (11), bolt (10), washer (9) and nut (8) on longer leg of seat back structure assembly (6).

(6) Install cushion assembly (3) and pillow assembly (2) on seat back structure assembly (6).

(7) Install cord (4) in cover assembly (1).

(8) Install and dress back cover (1) on seat back assembly while connecting literature pocket bungee cords.

(a) Seat appearance depends on cover dressing and is obtained by seam alignment. Even distribution of cover material on the foam is essential. This must be obtained by working the cover with the palm of the hand so that it lies in approximate positions before it is fastened down. The fold of all cord seams must lie on the top or bottom, front or back, but never on the side of the foam.

(b) The seam fold must be worked onto the top or the bottom, front or back of the foam as the cover is worked into place. In the wings beside the headrest, use a blunt, rounded-end rod to push the seam fold into position. Use fingers around remainder of seat where accessible. Normally, some portions of the seam fold are missed or will shift out of position. They are located by feeling along the seam edges after the cover is installed and then are adjusted by use of a sharp pointed awl. Slip point of awl 1/4 to 3/8 inch into material beside the seam fold. Move awl handle to pick up seam fold and work it into position. Avoid jabbing point of awl into foam.

(c) Velcro engagement must be obtained with mating edges flush and even so the cover is pulled evenly. Properly positioned, neither section of Velcro will be visible when fastened. To obtain proper dress in square corners of tray recess, fasten Velcro up to the corner to see if the corner is square. If the cover is so spaced that material will not fit into the corner (short), or if the material buckles in corner (long), use the point of the awl to hook Velcro for the side pull that will peel the corner open for a few inches to each side. Work the cover material with the hands to provide more material in a short corner or less material in long corner. Re-engage Velcro toward corner to obtain square corners.

(d) To install the cover, work the top over seat back top with seams matching the edge of the foam. Dress seam folds to lie on back front, but not on sides (use rod and awl point). When cover is positioned on upper back, hook cord below headrest.

(e) Dressing seam folds and working cover smooth, continue installation over front and sides of foam until bottom cover corners can be worked over foam to position the whole cover on the foam. Smooth and work cover for even distribution and proper fit. The key point is the inside rear corner at the base of the tray recess. The tip of the seam joint must lie even with the bottom edge of the material panel with the cover smooth and even but unfastened. If low, cover material has been worked too far toward bottom of foam; if high, cover has not been worked far enough down over foam.

(f) When cover and seams are properly dressed and aligned on foam, tack Velcro at bottom corners. Obtain seam alignment with aft foam edges near the center of the back to hold with a long pin through the aft face of the cover into the foam.

Dress cover across front face of foam to give aft edge seam alignment and pin at two to three inch intervals. Work down and up from first pin in center. In essence, the cover is worked into proper fit from base to bottom of headrest and pinned. The final dress is made as the Velcro is fastened along the side of the tray recess in the back.

(g) At the upper rear of the back, center the cutout of the cover evenly over the latch keeper and hook Velcro for an inch or two on each side. Smooth cover and work across top of tray recess, aligning seams while fastening Velcro. To clear the tray, it is important that Velcro makes a square corner in the tray recess corners. Work cover dress as necessary to obtain this result.

(h) Check entire back for neat appearance, even seams, and even and straight cloth pattern. Check that no Velcro or metal is visible.

(i) Install aft panel of back cover (8) in tray recess. Starting at top with good fit in corners, dress panel downward and toward sides to fasten the Velcro. Engage pocket cords to holes in back structure before fastening Velcro at this point.

N. Footrest Assembly (See IPC Figure 1, Sheet 3). Applicable on Usage Code A, M, P.

(1) Assemble lower footrest parts by installing upper and lower clamshells (180) and (181) on each crossbar assembly (177) with eight screws (183) and eight nuts (182). Install carpet assembly (178) over clamshells and zipper lock.

(2) Place two crossbar assemblies (177) with lower footrest parts attached in two brackets (159) and one bracket (160). Install four pawls (172), four springs (164), four springs (163), four washers (158), four bushings (157), four bushings (156), four triplates (155) and four washers (154).

(3) Install clevis pin (168), washer (166), pin (171), screw (176), washer (174), nut (173), screw (162), washer (153), nut (152), retaining ring (169) and cotter pin (165) on center bracket (160).

(4) Install clevis pin (167), washer (166), pin (170), screw (175), washer (174), nut (173), screw (161), retaining ring (169) and cotter pin (165) on inboard bracket (159).

(5) Install clevis pin (167), washer (166), pin (170), screw (175), washer (174), nut (173), screw (161), washer (153), and nut (152), retaining ring (169) and cotter pin (165) in outboard bracket (159).

(6) Applicable on usage code A only. Install footrest assembly (148) on aft underside of seat base assembly (217) using four screws (140) and six screws (150).

(7) Applicable on usage code M, P only. Install footrest assembly (148) on the aft underside of seat base assembly (217) using four bolts (149), two shims (151) and six bolts (150).

O. Fairings (See IPC Figure 1, Sheet 1)

(1) Install back fairing (60) on outboard leg of outboard seat back using four screws (61).

(2) Install back fairing (59) on the inboard leg of the inboard seat back using four screws (61).

(3) Install center hinge fairing (57) on aft side of seat base assembly (217) using four screws (58).

P. Food Tray Assembly (See IPC Figure 1, Sheet 1). Applicable on Usage Code A, D-G, K, M, P, Q.

(1) Install four bushings (44), two bushings (45) and four screws (43) in support assembly (42).

(2) Install table assembly (36) on support assembly (42) using four screws (32).

(3) Install latch (31) on table assembly (36) using three screws (30).

Q. Seat Back and Food Tray Assembly (See IPC Figure 1, Sheet 1).

(1) Install each seat back with two pins (5).

(2) At same time, install food tray assembly or dummy food tray (47) on each seat back if applicable on usage code A, D-G, K, M, P,Q.

(3) Unlatch food tray to pull tray support back and lower tray to horizontal position.

(4) Adjust tray support stops until tray pivot point is 25.5, plus or minus .50 inches from the floor with both stops contacting tray support (42).

(5) Adjust front set screws in tray support to bring top surface of food tray horizontal to floor level.

(6) Move tray installation to stowed position. If food tray does not align with tray support (42), adjust rear set screws in tray support.

(7) Move tray installation to stowed position and insure that food tray latches positively.

(8) Add or remove shims (27) behind latch (25) until no play exists between food tray latch and seat back latch.

(9) Raise or lower latch (25) until tang of latch has positive engagement of 0.120 to 0.150 inch with food tray latch.

R. Seat Cushions (See IPC Figure 1, Sheet 1)

(1) Install pad (50) on base assembly fairing using cement as specified in paragraph 3.D.(11).

(2) Pull cover (48) over cushion (49).

(3) Install and dress seat cushion assembly on seat base assembly (217). Dress covers to obtain seam alignment and smooth fabric with even distribution all around. Fasten Velcro on the underside of seat base assembly.

8. Testing

A. Seat Operation

(1) (See IPC Figure 1, Sheet 1.) Sitting in each seat, in turn, lift lever to check reclining action of seat back. Seat back must recline smoothly and lock in position when lever is released.

(2) Lean forward to take weight off seat back. Lift lever and check that back recovers to normal position.

(3) Repeat operations described in steps (1) and (2) at least three times.

(4) Set seat back in reclined position. With lever down, check that seat back can be manually returned to normal position without undue force. Check that seat back locks in normal position.

(5) Apply 35 pound forward pull at top center of seat back and check how breakover mechanism releases to allow seat to fold forward. If necessary, adjust bolt at breakover mechanism to adjust compression of spring until correct setting is obtained.

(6) Check operation and position of food tray in open and closed positions. If necessary, adjust as described in paragraphs 6.Q.(3) through (9).

9. Trouble Shooting

PASSENGER SEAT ASSEMBLY

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
A. Recline Lever Will Not Lift, or Lifts But Fails to Unlock Seat Back	
(1) Defective seat lock. (See IPC Figure 1, Sheet 2.)	Replace seat lock unit. Check lever, clevis, upper end of cable, and nylon tube for bind or breakage. Look up under seat base to observe arm at front of seat lock. Move lever and insure linkage and cable move with it. Free or replace parts as necessary.
(2) Broken or sticking elements in cable and linkage between lever and seat lock.	
B. Recline Lever Sticks in Raised Position	
(1) Defective spring at seat lock. (See IPC Figure 1, Sheet 2.)	Check through base structure channel for loose, stretched, or broken spring. Rectify.
(2) Cable assembly binding.	Check for binding at lower end of cable. Check for binding at upper end of cable. Rectify binding condition.
C. Seat Back Fails to Lock or Recover When Seat Lock Operated	
(1) Defective seat lock. (See IPC Figure 1, Sheet 2.)	Replace seat lock.
D. Food Tray Fails to Latch Closed	
(1) Defective seat latch (25). (See IPC Figure 1, Sheet 1.)	Check seat latch operation. Replace seat latch (25).
(2) Defective tray latch (31). (See IPC Figure 1, Sheet 1.)	Check tray latch operation. Replace tray latch (31).
(3) Maladjusted latches	Check latch adjustment; refer to paragraphs 6Q.(7) to (9).
(4) Food tray pivot distorted, or sheared. (See IPC Figure 1, Sheet 1.)	Replace food tray assembly.
E. Food Tray Not Level in Down Position	
(1) Food tray support stops (244), (245) or (246) moved. (See IPC Figure 1, Sheet 4.)	Loosen bolts (247) and adjust stops; refer to paragraph 6Q.(4).

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
F. Seat Back Folds Forward Past Normal Position With Light Push	
(1) Maladjusted breakover assembly. (See IPC Figure 1, Sheet 2.)	Check breakover adjustment; refer to paragraph 8A.(5).
(2) Broken breakover assembly.	Check breakover assembly for obvious damage. Replace breakover assembly if necessary.
G. Seat Back Fails to Fold Foward on Impact	
(1) Maladjusted breakover. (See IPC Figure 1, Sheet 2)	Check breakover adjustment; refer to paragraph 8A.(5).
H. Footrest Will Not Lift, or Lifts But Fails to Lock	
(1) Broken or sticking elements in footrest assembly at upper pivot. (See IPC Figure 1, Sheet 3.)	Check footrest ratchet pawl (172) and footrest ratchet triplate for bind or breakage. Free or replace parts as necessary.
J. Footrest Crossbar Pivots Without Locking	
(1) Broken pin stop on crossbar assembly (177). (See IPC Figure 1, Sheet 3.)	Replace crossbar assembly.

10. Storage Instructions

A. The seat assembly is essentially corrosion resistant and no special preservation is required.

B. For maximum space in storage, demount seat back and tray group and center armrest. Keep removed parts with applicable assembly.

C. Wrap seat in waterproof wrapping paper specified in paragraph 3.D.(16) or a plastic cover. Use tape specified in paragraph 3.D.(17), or equivalent, to secure wrapping paper or cover. Stamp seat assembly part number and date of overhaul on a tag or in a convenient location on seat wrapper.

D. Store seat in a cool dry area, below 68 degrees F, away from sunlight and heat source.

11. Special Tools, Fixtures and Equipment

A. While not essential, a frame or fixture to simulate the mounting provisions in the airplane will assist disassembly and assembly.

B. No other special tools, fixtures, or equipment are required.

CONVAIR
JET AIRLINER

OVERHAUL MANUAL
ILLUSTRATED PARTS CATALOG

PASSENGER SEAT ASSEMBLIES - DOUBLE
(Convair Part Nos. 31-92503 and 30-94551 Series)

ATA NO. 25-2-32

Applicable To Models 22(M)-3, 22(M)-4, 22(M)-22, 30-5, 30-6, and 30-8

July 5/62

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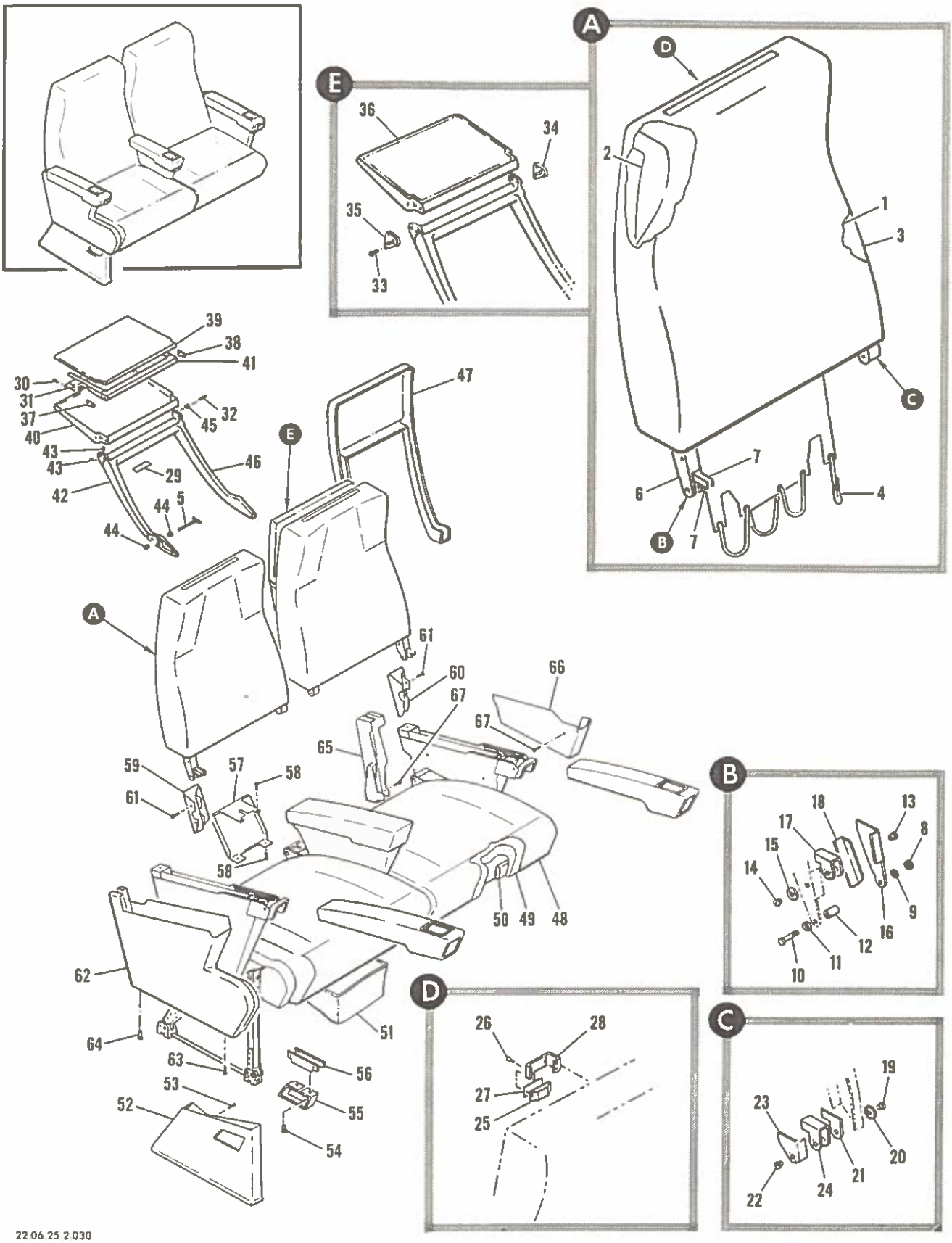
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22-92371-8		1 - 38	1
22-92374-851		1 - 191	2
22-92374-853		1 - 195	2
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22-92425-207		1 - 29	2
22-92516-7		1 - 231	2
22-92518-201		1 - 245	1
22-92518-202		1 - 246	1
22-92518-7		1 - 244	2
22-92519-203		1 - 221	1
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22-92538-851		1 - 98	2
22-92539-7		1 - 89	1
22-92540-801		1	1
22-92542-851		1 - 210	1
22-92543-851		1 - 206	2
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22-92547-203		1 - 192	
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22-92550-801		1	2
22-92550-811		1	2
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22-92557-201		1 - 28	1
22-92558-13		1 - 49	2
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30-93525-7		1 - 163	4
30-93527-7		1 - 172	4
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30-93567-15		1 - 178	2
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30-93567-3		1 - 148	1
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30-93570-8		1 - 202	1
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31-92323-851		1	2
31-92323-857		1	1
31-92323-9		1 - 119	1
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31-92330-201		1 - 66	1
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31-92330-203		1 - 65	1
31-92330-204		1	1
31-92330-805		1 - 52	1
31-92330-806		1	1
31-92330-811		1	1
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31-92518-852		1	1
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31-92570-812		1	1
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31-93302-1		1 - 51	2
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	31-92503-810	SEAT ASSEMBLY, DOUBLE COACH PASSENGER RH -V83115-	C			1
	31-92503-803	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	D			1
	31-92503-804	SEAT ASSEMBLY, DOUBLE COACH PASSENGER RH -V83115-	E			15
	31-92503-1	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	F			13
	30-94551-858	SEAT ASSEMBLY, DOUBLE COACH PASSENGER RH -V83115-	G			12
	30-94551-861	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	H			1
	30-94551-862	SEAT ASSEMBLY, DOUBLE COACH PASSENGER RH -V83115-	J			1
	30-94551-852	SEAT ASSEMBLY, DOUBLE COACH PASSENGER RH -V83115-	K			13
	30-94551-864	SEAT ASSEMBLY, DOUBLE COACH PASSENGER RH -V83115-	L			1
	30-94551-853	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	M			7
	30-94551-855	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	N			1
	30-94551-867	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	P			15
	30-94551-859	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	Q			7
	30-94551-865	SEAT ASSEMBLY, DOUBLE COACH PASSENGER LH -V83115-	R			1
	22-92337-805	. BACK ASSEMBLY, INBD -V83115-	A-C			1
	22-92337-806	. BACK ASSEMBLY, OUTBD -V83115-	A-C			1
	22-92337-819	. BACK ASSEMBLY, INBD -V83115-	D-E			1
	22-92337-820	. BACK ASSEMBLY, OUTBD -V83115-	D-E			1
	22-92337-803	. BACK ASSEMBLY, INBD -V83115-	F			1
	22-92337-804	. BACK ASSEMBLY, OUTBD -V83115-	F			1
	22-92337-807	. BACK ASSEMBLY, INBD -V83115-	G-R			1
	22-92337-808	. BACK ASSEMBLY, OUTBD -V83115-	G-R			1
- 1	22-92381-801	. COVER ASSEMBLY, DOUBLE COACH SEAT BACK -V83115-	A-C			2
	22-92381-823	. COVER ASSEMBLY, DOUBLE COACH SEAT BACK -V83115-	D-E			2
	22-92381-809	. COVER ASSEMBLY, DOUBLE COACH SEAT BACK -V83115-	F			2
	22-92381-815	. COVER ASSEMBLY, DOUBLE COACH SEAT BACK -V83115-	G-R			2
- 2	22-92382-1	. PILLOW ASSEMBLY, PASSENGER SEAT HEADREST -V83115-	A-C			2
- 3	22-92379-1	. CUSHION ASSEMBLY, SEAT BACK BONDED -V83115-	A-C			2
	30-93504-5	. CUSHION ASSEMBLY, SEAT BACK BONDED -V83115-	D-R			2
- 4	22-92596-803	. CORD, SEAT BACK ELASTIC -V83115-	A-C,	F		3
	22-92596-803	. CORD, SEAT BACK ELASTIC -V83115-	D-E,	G-R		1
- 5	NAS1335A2C33	. PIN, QUICK DISCONNECT	A-R			4
- 6	31-92560-1	. BACK ASSEMBLY, STRUCTURE INBD -V83115-	A-R			1
	31-92560-2	. BACK ASSEMBLY, STRUCTURE OUTBD -V83115-	A-R			1
- 7	22-94502-9	. . GUIDE, SEAT BACK -V83115-	A-R			2
- 8	NAS679A5	. . NUT	A-R			1
- 9	AN960D516L	. . WASHER	A-R			1
- 10	NAS1205-18	. . BOLT	A-R			1
- 11	22-92568-17	. . WASHER, SEAT BACK -V83115-	A-R			1
- 12	22-92352-7	. . SPACER, MECHANISM ATTACH BACK -V83115-	A-R			1
- 13	NAS77-5-20	. . BUSHING	A-R			1
- 14	NAS77-5-27	. . BUSHING	A-R			1
- 15	22-92568-11	. . WASHER, SEAT BACK -V83115-	A-R			1
- 16	22-92568-7	. . ANGLE, SEAT BACK INBD -V83115-	A-R			1
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- 17	22-92568-13	. . CHANNEL, SEAT BACK -V83115-	A-R			1
- 18	22-92568-9	. . CLIP, SEAT BACK INBD -V83115-	A-R			1
	22-92568-10	. . CLIP, SEAT BACK OUTBD -V83115-	A-R			1
- 19	NAS77-5-22	. . BUSHING	A-R			1
- 20	22-92568-11	. . WASHER, SEAT BACK -V83115-	A-R			1
- 21	22-92569-25	. . SHIM, SEAT BACK -V83115-	A-R			1
- 22	NAS77-5-20	. . BUSHING	A-R			1
- 23	22-92568-15	. . ANGLE, SEAT BACK INBD -V83115-	A-R			1
	22-92568-16	. . ANGLE, SEAT BACK OUTBD -V83115-	A-R			1
- 24	22-92568-13	. . CHANNEL, SEAT BACK -V83115-	A-R			1
- 25	H311-11	. . LATCH, FOOD TRAY -V83015- ATTACHING PARTS	A-R			1
- 26	NAS623-2-3	. . SCREW	A-R			2
- 27	22-92569-23	. . SHIM, SEAT BACK -V83115- ----x----	A-R			2
- 28	22-92557-201	. . BRACKET, FOOD TRAY LATCH -V83115-	A-R			1
- 29	22-92425-207	. PLACARD, LIFE VEST STOWAGE -V83115-	D-E			2
	22-92425-201	. PLACARD, LIFE VEST STOWAGE -V83115-	F-J			2
	22-92425-205	. PLACARD, LIFE VEST STOWAGE -V83115-	P			2

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -	22-92550-801	. TRAY INSTALLATION, FOOD -V83115-	A,D-M,P	E,G,	K,	2
	22-92550-811	. TRAY INSTALLATION, FOOD -V83115-	Q			2
	22-92550-813	. TRAY INSTALLATION, FOOD -V83115-	F			2
- 30	AN507DD1032R6	. . SCREW	A,D-P-Q	G,K,	M,	3
- 31	H311-17	. . LATCH, CONVAIR 95-51300-008 -V83015-	A			1
	H311-21	. . LATCH, CONVAIR 95-51300-010 -V83015-	D-G,	K,M,	P-Q	1
- 32	22-92355	. . SCREW, TABLE TRAY PIVOT -V83115-	A,D-P-Q	G,K,	M,	4
- 33	AN507-440R6	. . SCREW	Q			6
- 34	30-93801-7	. . PLATE, FOOD TRAY TABLE FRICTION LH -V83115-	Q			1
- 35	30-93801-8	. . PLATE, FOOD TRAY TABLE FRICTION RH -V83115-	Q			1
- 36	22-92552-801	. . TABLE ASSEMBLY, FOOD TRAY -V83115-	A,D-M,P-Q	E,G,	K,	1
	22-92552-807	. . TABLE ASSEMBLY, FOOD TRAY -V83115-	F			1
- 37	22-92371-7	. . . SPACER, FOOD TRAY PIVOT LH -V83115-	A,D-P-Q	G,K,	M,	1
- 38	22-92371-8	. . . SPACER, FOOD TRAY PIVOT RH -V83115-	A,D-P-Q	G,K,	M,	1
- 39	22-92554-21	. . . SHELL, FOOD TRAY BONDED -V83115-	A,D-M,P-Q	E,G,	K,	1
	22-92554-29	. . . SHELL, FOOD TRAY BONDED -V83115-	F			1
- 40	22-92554-25	. . . SHELL ASSEMBLY, FOOD TRAY BONDED -V83115-	A,D-P-Q	G,K,	M,	1
- 41	22-92555-1	. . . STRUCTURE ASSEMBLY, TRAY TABLE RIVETED -V83115-	A,D-P-Q	G,K,	M,	1
- 42	22-92551-3	. . SUPPORT ASSEMBLY, TRAY TABLE -V83115-	A,D-	G,K,	M,P	1
	22-92551-201	. . SUPPORT ASSEMBLY, TRAY TABLE -V83115-	Q			1
- 43	AN565D1032H3	. . . SCREW	A,D-P-Q	G,K,	M,	4
- 44	NAS77-5-38	. . . BUSHING	A,D-P-Q	G,K,	M,	4
- 45	NAS75-3-016	. . . BUSHING	A,D-P-Q	G,K,	M,	2
- 46	22-92551-9	. . . SUPPORT, -V83115-	A,D-P-Q	G,K,	M,	1
- 47	22-92361-5	. FAIRING ASSEMBLY, INBD FOOD TRAY DUMMY RIVETED -V83115-	B-C, N,R	H-J,	L,	1
	22-93698-803	. CUSHION ASSEMBLY, INBD AND OUTBD BOTTOM -V83115-	A-R			2
- 48	22-93698-17	. COVER, INBD AND OUTBD SEAT BOTTOM -V83115-	A-R			2
	22-93698-9	. STRAP, BOTTOM COVER STITCHED -V83115-	A-R			2
- 49	22-92558-13	. CUSHION, SEAT BOTTOM FOAM -V83115-	A-R			2
- 50	22-92559-203	. PAD, BOTTOM CUSHION FOAM -V83115-	A-R			2
- 51	31-93302-1	. CONTAINER ASSEMBLY, LIFE VEST STITCHED -V83115-	A-J,	P		2
- 52	31-92330-805	. FAIRING ASSEMBLY, DOUBLE COACH SEAT LEG LH BONDED -V83115-	B,D,	F,H,	P	1
	31-92330-811	. FAIRING ASSEMBLY, DOUBLE COACH SEAT LEG LH BONDED -V83115-	M-N,	Q-R		1
	31-92330-806	. FAIRING ASSEMBLY, DOUBLE COACH SEAT LEG RH BONDED -V83115-	A,C,	E,G,	J-L	1
		ATTACHING PARTS				
- 53	AN526-1032R12	. SCREW	A-R			5
		----x----				
- 54	AN509-416R15	. SCREW	M-N,	Q-R		2
- 55	30-93573-7	. STEP, DOUBLE COACH STEWARDESS -V83115-	M-N,	Q-R		1
- 56	30-93574-7	. CHANNEL, STEWARDESS STEP UPPER -V83115-	M-N,	Q-R		1
- 57	31-92554-7	. FAIRING, COACH SEAT CENTER HINGE -V83115-	A-R			1
		ATTACHING PARTS				
- 58	AN526-832R8	. SCREW	A-R			4
		----x----				
- 59	22-92332-13	. FAIRING, INBD BACK LH -V83115-	A,C,	E,G,	J-L	1
	22-92332-14	. FAIRING, INBD BACK RH -V83115-	B,D,	F,H,	M-R	1
- 60	22-92332-9	. FAIRING, OUTBD BACK LH -V83115-	A,C,	E,G,	J-L	1
	22-92332-10	. FAIRING, OUTBD BACK RH -V83115-	B,D,	F,H,	M-R	1

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -		ATTACHING PARTS				
- 61	AN526-632R6	. SCREW	A-R			8
		----x----				
- 62	31-92330-1	. FAIRING ASSEMBLY, COACH SEAT INBD ARM LH BONDED -V83115-	B,D,	F,H,	M-R	1
	31-92330-2	. FAIRING ASSEMBLY, COACH SEAT INBD ARM RH BONDED -V83115-	A,C,	E,G,	J-L	1
		ATTACHING PARTS				
- 63	AN526-632R6	. SCREW	A-R			AR
- 64	AN526-1032R6	. SCREW	A-R			AR
		----x----				
- 65	31-92330-203	. FAIRING, COACH SEAT OUTBD ARM LH -V83115-	B,D,	F,H,	M-R	1
	31-92330-204	. FAIRING, COACH SEAT OUTBD ARM RH -V83115-	A,C,	E,G,	J-L	1
- 66	31-92330-201	. FAIRING, COACH SEAT OUTBD ARM LH -V83115-	B,D,	F,H,	M-R	1
	31-92330-202	. FAIRING, COACH SEAT OUTBD ARM RH -V83115-	A,C,	E,G,	J-L	1
		ATTACHING PARTS				
- 67	AN526-632R6	. SCREW	A-R			5

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

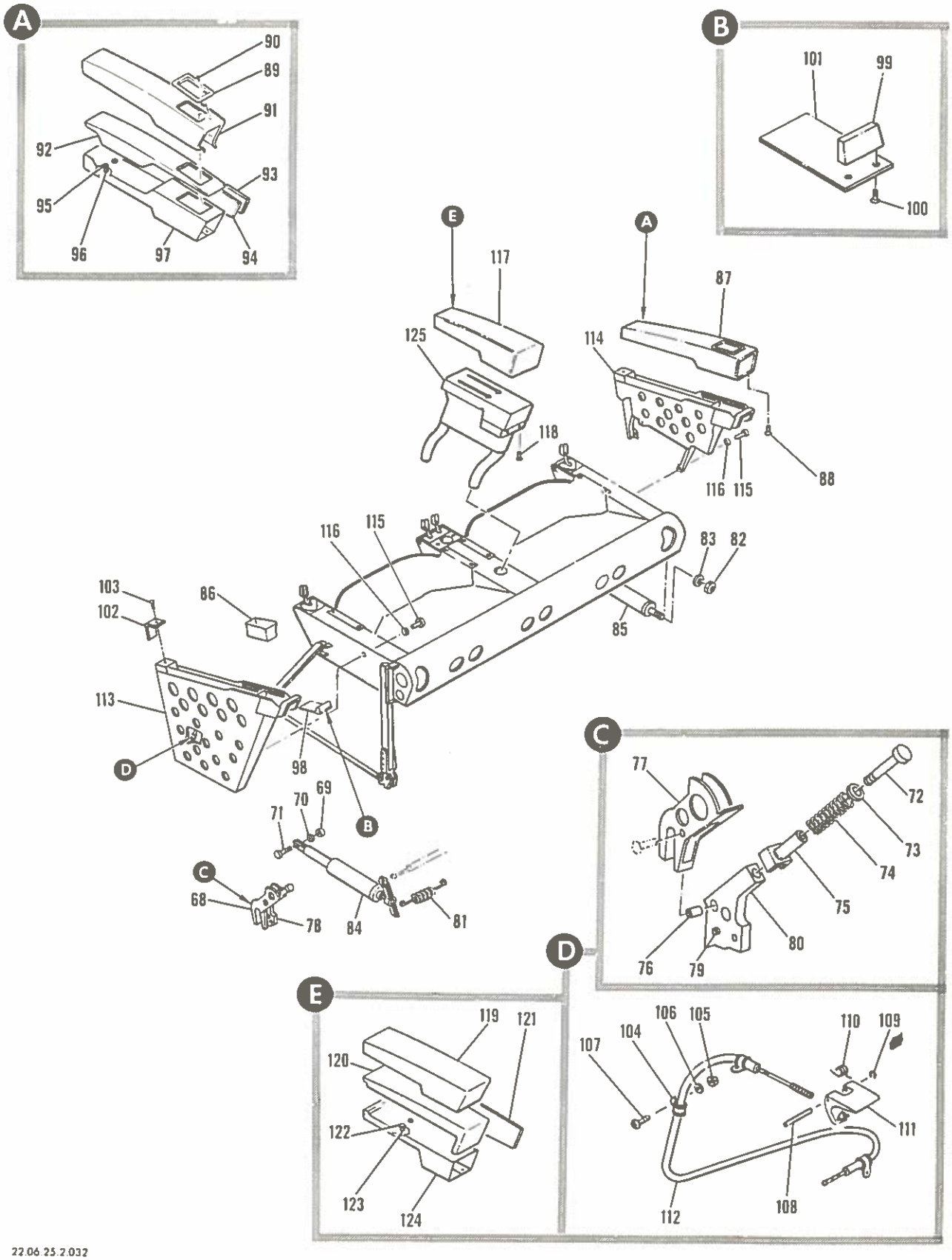
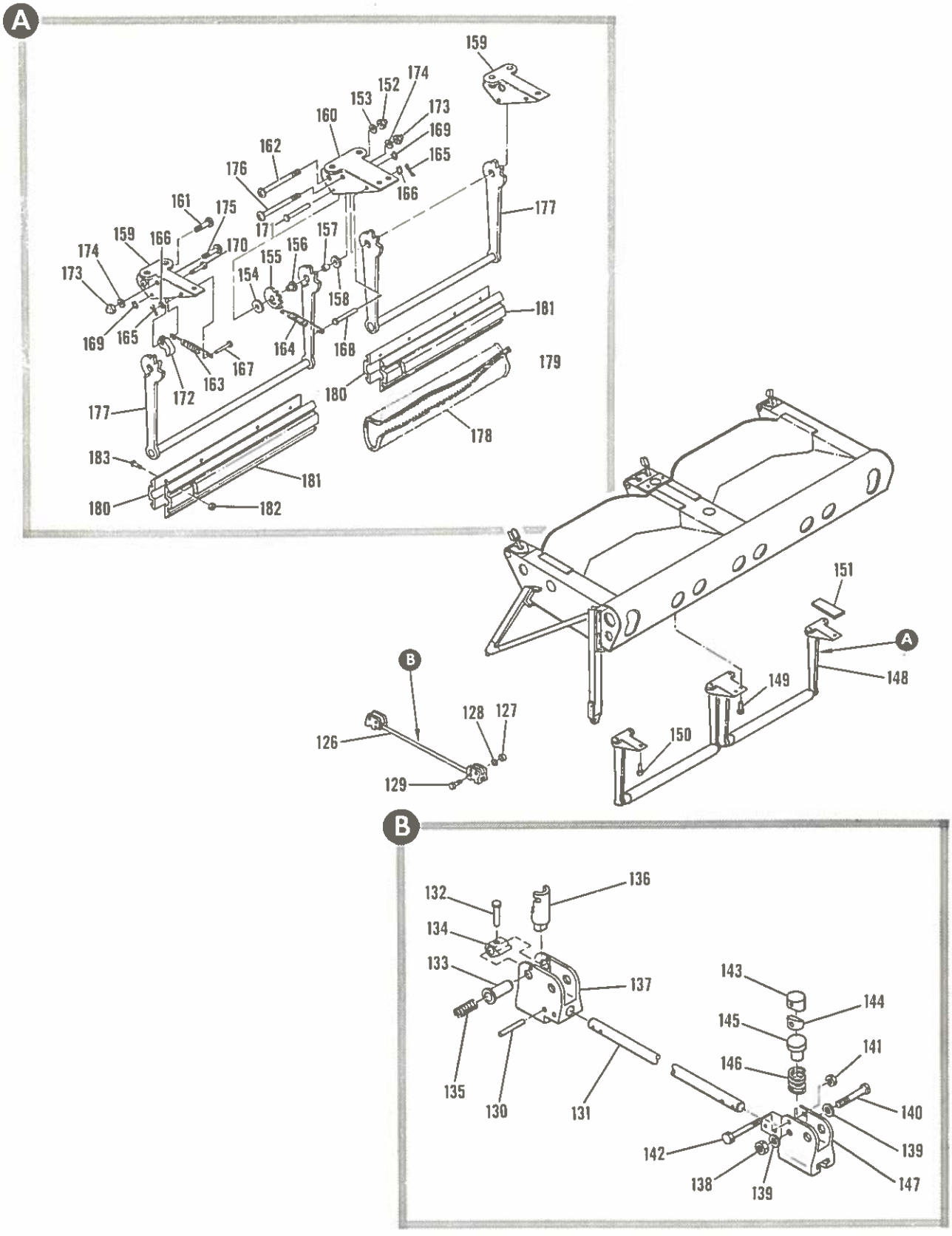

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 68	22-92587-803	. BREAKOVER ASSEMBLY, SEAT BACK -V83115-	A-L,	P		2
	22-92587-5	. BREAKOVER ASSEMBLY, SEAT BACK INBD -V83115-	M-N,	Q-R		1
	22-92587-803	. BREAKOVER ASSEMBLY, SEAT BACK OUTBD -V83115- ATTACHING PARTS				
- 69	AN364-1032	. NUT	A-R			2
- 70	AN960D10L	. WASHER	A-R			2
- 71	NAS1103-9	. BOLT	A-R			2
		----x----				
- 72	AN3-15A	. . BOLT	A-R			1
- 73	AN960D416	. . WASHER	A-R			1
- 74	22-92589-201	. . SPRING, BREAKOVER COMPRESSION -V83115-	A-L,	P		1
	22-92589	. . SPRING, BREAKOVER COMPRESSION INBD -V83115-	M-N,	Q-R		1
	22-92589-201	. . SPRING, BREAKOVER COMPRESSION OUTBD -V83115-	M-N,	Q-R		1
- 75	22-92358-7	. . STOP, BREAKOVER FITTING -V83115-	A-R			1
- 76	22-92352-9	. . SPACER, MECHANISM ATTACH BACK -V83115-	A-R			1
- 77	22-94526-11	. . YOKE, BREAKOVER FITTING -V83115-	A-R			1
- 78	22-92356	. . BLOCK ASSEMBLY, BREAKOVER -V83115-	A-R			1
- 79	22-92357	. . . PIN, BREAKOVER FITTING -V83115-	A-R			1
- 80	22-92356-7	. . . BLOCK, BREAKOVER FITTING -V83115-	A-R			1
- 81	31-92505-9	. SPRING, SEAT LOCK LEVER -V83115-	D-R			2
- 82	AN364-624	. NUT	A-R			2
- 83	AN960D616	. WASHER	A-R			AR
	22-94517-9	. SPRING, SEAT LOCK HELPER -V83115-	A-C			4
	AN380-2-2	. PIN, COTTER	A-C			2
	22-94516	. PIN, SEAT LOCK HELPER SPRING -V83115-	A-C			2
- 84	SL3500	. LOCK, SEAT POSITIONER INBD CONVAIR 96-93500-003 -V02953-	D-F			1
- 85	SL3500-1	. LOCK, SEAT POSITIONER OUTBD CONVAIR 96-93500-004 V-02953-	D-F			1
	SL3500-2	. LOCK, SEAT POSITIONER INBD CONVAIR 96-93500-010 -V02953-	G-R			1
	SL3500-3	. LOCK, SEAT POSITIONER OUTBD CONVAIR 96-93500-011 -V02953-	G-R			1
	L33-1037-00	. LOCK, SEAT POSITIONER INBD AND OUTBD CONVAIR 96-93500-008 -V45402-	A-C			2
- 86	22-92536	. ASH TRAY ASSEMBLY, INBD AND OUTBD ARMCAP RIVETED -V83115-	A-C,	F-R		2
	22-94506-3	. ASH TRAY ASSEMBLY, INBD ARMCAP -V83115-	D-E			1
	22-94506-4	. ASH TRAY ASSEMBLY, OUTBD ARMCAP -V83115-	D-E			1
	22-92540-801	. . COVER AND ESCUTCHEON ASSEMBLY, RIVETED -V83115-	D-E			1
	22-94507-1	. . RECEIVER ASSEMBLY, ASH TRAY INBD RIVETED -V83115-	D-E			1
	22-94507-2	. . RECEIVER ASSEMBLY, ASH TRAY OUTBD RIVETED -V83115-	D-E			1
- 87	31-92323-801	. COVER ASSEMBLY, INBD AND OUTBD ARMREST -V83115-	A-C,	F-P		2
	31-92323-851	. COVER ASSEMBLY, INBD AND OUTBD ARMREST -V83115-	Q-R			2
	31-92323-805	. COVER ASSEMBLY, INBD AND OUTBD ARMREST -V83115- ATTACHING PARTS	D-E			2
- 88	AN526-1032R6	. SCREW	A-R			4
		----x----				
- 89	22-92539-7	. . ESCUTCHEON ASSEMBLY, ASH TRAY WELDED -V83115- ATTACHING PARTS	A-C,	F-R		1
- 90	AN507-632R5	. . SCREW	A-C,	F-R		1
		----x----				
- 91	31-92323-21	. . COVER, ARMREST -V83115-	A-C,	F-P		1
	31-92323-203	. . COVER, ARMREST -V83115-	Q-R			1
	31-92323-29	. . COVER, ARMREST -V83115-	D-E			1
- 92	31-92380-13	. . PAD, ARMCAP TOP -V83115-	A-C,	F-P		1
	31-92380-203	. . PAD, ARMCAP TOP -V83115-	Q-R			1
	31-92380-17	. . PAD, ARMCAP TOP -V83115-	D-E			1
- 93	31-92323-23	. . PAD, ARMREST SIDE -V83115-	A-R			2
- 94	31-92323-205	. . PAD, ARMREST SIDE -V83115-	A-R			2
- 95	AN960-8L	. . WASHER	A-R			2
- 96	22-92598-7	. . PIN, ARMCAP -V83115-	A-R			2
- 97	31-92321-1	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	A-C,	F-R		1
	31-92321-803	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	D-E			1
- 98	22-92538-851	. COVER ASSEMBLY, ASH TRAY -V83115-	A-C,	F-R		2
		SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 99	22-92538-203	. . KNOB, ASH TRAY COVER V83115-	A-C,	F-R		1
		ATTACHING PARTS				
-100	AN507-440R3	. . SCREW	A-C,	F-R		2
		----x----				
-101	22-92538-201	. . PLATE, ASH TRAY COVER -V83115-	A-C,	F-R		1
-102	22-92315-13	. CAP ASSEMBLY, INBD AND OUTBD SCUFF WELDED -V83115-	A-R			2
		ATTACHING PARTS				
-103	AN507-1032R5	. SCREW	A-R			2
		----x----				
-104	MS21919DG4	. CLAMP	A-R			6
		ATTACHING PARTS				
-105	NAS679A08	. NUT	A-R			6
-106	AN960D8	. WASHER	A-R			6
-107	AN526-832R8	. SCREW	A-R			6
		----x----				
-108	31-92593-9	. PIN, RECLINE LEVER -V83115-	A-R			2
-109	5133-25	. RING, EXTERNAL RETAINING	A-R			4
		CONVAIR 97-61504-004 -V79136-				
-110	22-94504-201	. SPRING, RECLINE LEVER -V83115-	A-R			2
-111	22-94503-215	. LEVER ASSEMBLY, SEAT RECLINE RIVETED -V83115-	A-R			2
	MS20392-1-9	. PIN, CLEVIS	A-C			2
	AN960C4L	. WASHER	A-C			2
	22-94510	. FORK, RECLINE END -V83115-	A-C			2
-112	30-93555-859	. CABLE ASSEMBLY, INBD AND OUTBD SEAT LOCK SWAGED	A-C			2
		-V83115-				
	30-93555-1	. CABLE ASSEMBLY, INBD AND OUTBD SEAT LOCK SWAGED	D-R			2
		-V83115-				
-113	31-92570-1	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	B,F,	H,M-	R	1
	31-92570-805	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	D			1
	31-92570-2	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	A,C,	G,J-	L	1
	31-92570-806	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	E			1
-114	31-92570-802	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	B,F,	H,M-	R	1
	31-92570-812	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	D			1
	31-92570-801	. STRUCTURE ASSEMBLY, OUTBD ARMREST RH RIVETED -V83115-	A,C,	G,J-	L	1
	31-92570-811	. STRUCTURE ASSEMBLY, OUTBD ARMREST RH RIVETED -V83115-	E			1
		ATTACHING PARTS				
-115	NAS1104-3	. BOLT	A-R			6
-116	AN960D416L	. WASHER	A-R			6
		----x----				
-117	31-92323-1	. COVER ASSEMBLY, CENTER ARMREST -V83115-	A-P			1
	31-92323-857	. COVER ASSEMBLY, CENTER ARMREST -V83115-	Q-R			1
		ATTACHING PARTS				
-118	AN526-832R6	. SCREW	A-R			2
		----x----				
-119	31-92323-9	. . COVER, ARMREST -V83115-	A-P			1
	31-92323-201	. . COVER, ARMREST -V83115-	Q-R			1
-120	31-92380-7	. . PAD, ARMCAP TOP -V83115-	A-P			1
	31-92380-201	. . PAD, ARMCAP TOP -V83115-	Q-R			1
-121	31-92323-7	. . PAD, ARMREST SIDE -V83115-	A-R			2
-122	AN960-8L	. . WASHER	A-R			2
-123	22-92598-7	. . PIN, ARMCAP -V83115-	A-R			2
-124	31-92321-15	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	A-R			1
-125	31-92595-1	. ARMREST ASSEMBLY, CENTER BONDED -V83115-	A-R			1

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

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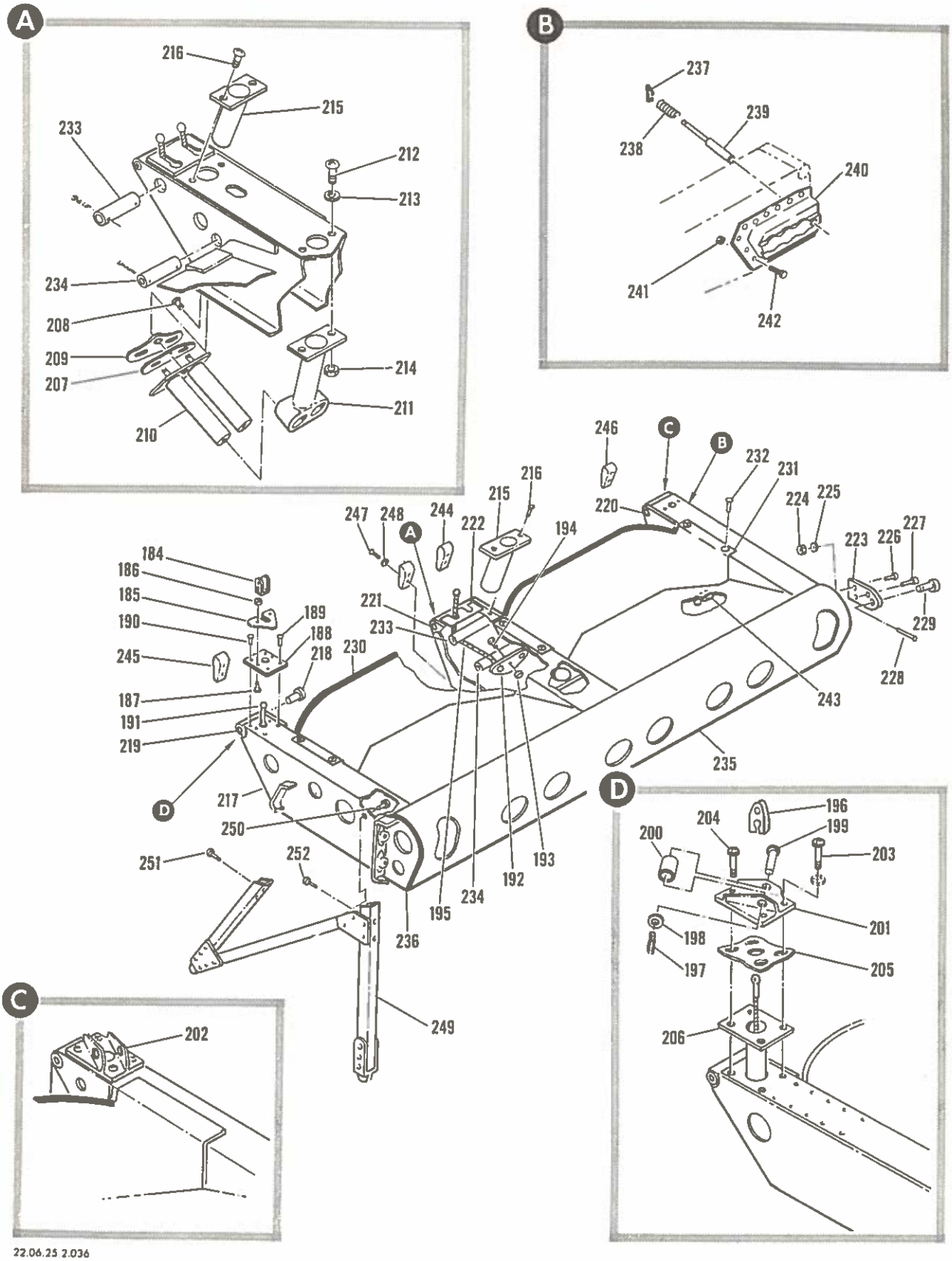
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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -126	30-94520-1	. FOOT ASSEMBLY, PASSENGER SEAT LH -V83115-	B,D,	F,H,	M-R	1
	30-94520-2	. FOOT ASSEMBLY, PASSENGER SEAT RH -V83115-	A,C,	E,G,	J-L	1
		ATTACHING PARTS				
-127	NAS1291-6	. NUT	A-R			2
-128	AN960-616L	. WASHER	A-R			2
-129	NAS623-6-13	. SCREW	A-R			2
		----x----				
-130	NAS561P3-15	. . PIN, ROLL	A-R			4
-131	30-94520-7	. . TUBE, -V83115-	A-R			1
	30-94520-801	. . FITTING ASSEMBLY, AFT LH -V83115-	B,D,	F,H,	M-R	1
	30-94520-802	. . FITTING ASSEMBLY, AFT RH -V83115-	A,C,	E,G,	J-L	1
	AN381-2-6	. . . PIN, COTTER	A-R			1
-132	MS20392-1-19	. . . PIN, CLEVIS	A-R			1
-133	30-94529-7	. . . PLUNGER, AFT FLOOR FITTING -V83115-	A-R			1
-134	30-94528-201	. . . DRIVER, AFT FLOOR FITTING -V83115-	A-R			1
-135	30-94530-7	. . . SPRING, AFT FLOOR FITTING COMPRESSION -V83115-	A-R			1
-136	30-94531-7	. . . PIN, AFT FLOOR FITTING LOCK -V83115-	A-R			1
-137	30-94526-7	. . . FITTING, AFT FLOOR LH -V83115-	B,D,	F,H,	M-R	1
	30-94526-8	. . . FITTING, AFT FLOOR RH -V83115-	A,C,	E,G,	J-L	1
	30-94520-5	. . FITTING ASSEMBLY, FWD LH -V83115-	B,D,	F,H,	M-R	1
	30-94520-6	. . FITTING ASSEMBLY, FWD RH -V83115-	A,C,	E,G,	J-L	1
	AN380-2-3	. . . PIN, COTTER	A-R			1
-138	AN320C3	. . . NUT	A-R			1
-139	AN960C10L	. . . WASHER	A-R			2
-140	AN502-10-20	. . . SCREW	A-R			1
-141	AN364-1032	. . . NUT	A-R			1
-142	AN3C12A	. . . BOLT	A-R			1
-143	30-94522-7	. . . BLOCK, FWD FLOOR FITTING -V83115-	A-R			1
-144	30-94524-7	. . . WEDGE, FWD FLOOR FITTING -V83115-	A-R			1
-145	30-94523-7	. . . PLUNGER, FWD FLOOR FITTING -V83115-	A-R			1
-146	30-94525-7	. . . SPRING, FWD FLOOR FITTING COMPRESSION -V83115-	A-R			1
-147	30-94521-7	. . . FITTING, FWD FLOOR -V83115-	A-R			1
-148	30-93567-3	. FOOTREST ASSEMBLY, DOUBLE COACH SEAT -V83115-	A,M,	P		1
		ATTACHING PARTS				
-149	AN509-10R8	. SCREW	A			4
	NAS1203-5	. BOLT	M,P			4
-150	AN509-10R10	. SCREW	A			6
	NAS1203-6	. BOLT	M,P			6
-151	22-92569-17	. SHIM, BASE FRAME FOOTREST -V83115-	M,P			2
		----x----				
-152	52NKTE048	. . NUT, SELF-LOCKING CAP NYLON	A,M,	P		2
		CONVAIR 96-37568-004 -V72962-				
-153	AN960PD416L	. . WASHER	A,M,	P		2
-154	AN960-616	. . WASHER	A,M,	P		4
-155	30-93523-7	. . TRIPLATE, FOOTREST RATCHET -V83115-	A,M,	P		4
-156	NAS77-4-20	. . BUSHING	A,M,	P		4
-157	NAS75-4-010	. . BUSHING	A,M,	P		4
-158	22-92420-7	. . WASHER, FOOTREST NYLON -V83115-	A,M,	P		4
-159	30-93531-9	. . BRACKET, FOOTREST ATTACHMENT -V83115-	A,M,	P		2
-160	30-93531-7	. . BRACKET, FOOTREST ATTACHMENT -V83115-	A,M,	P		1
-161	NAS623-4-12	. . SCREW	A,M,	P		2
-162	NAS623-4-24	. . SCREW	A,M,	P		1
-163	30-93525-7	. . SPRING, EXTENSION -V83115-	A,M,	P		4
-164	30-93534-7	. . SPRING, EXTENSION -V83115-	A,M,	P		4
-165	AN380-1-2	. . PIN, COTTER	A,M,	P		3
-166	AN960PD8	. . WASHER	A,M,	P		3
-167	MS20392-1-25	. . PIN, CLEVIS	A,M,	P		2
-168	MS20392-1-47	. . PIN, CLEVIS	A,M,	P		1
-169	5103-15	. . RING, RETAINING SNAP	A,M,	P		3
		CONVAIR 97-61512-004 -V89462-				
-170	22-92419-7	. . PIN, FOOTREST STOP -V83115-	A,M,	P		2
-171	22-92419-9	. . PIN, FOOTREST STOP -V83115-	A,M,	P		1
-172	30-93527-7	. . PAWL, FOOTREST RATCHET -V83115-	A,M,	P		4
		ATTACHING PARTS				
-173	52NKTE048	. . NUT, SELF-LOCKING CAP NYLON	A,M,	P		3
		CONVAIR 96-37568-004 -V72962-				
		SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -174	AN960PD416L	. . WASHER	A,M,	P		3
-175	NAS623-4-12	. . SCREW	A,M,	P		2
-176	NAS623-4-24	. . SCREW	A,M,	P		1
		----x----				
-177	30-93565-5	. . CROSSBAR ASSEMBLY, FOOTREST INBD AND OUTBD WELDED -V83115-	A,M,	P		2
-178	30-93567-15	. . CARPET, FOOTREST STITCHED -V83115-	A,M,	P		2
-179	30-93567-29	. . ZIPPER, FOOTREST STITCHED -V83115-	A,M,	P		2
-180	30-93566-21	. . CLAMSHELL, FOOTREST CROSSBAR UPPER -V83115-	A,M,	P		2
-181	30-93566-207	. . CLAMSHELL, FOOTREST CROSSBAR LOWER -V83115-	A,M,	P		2
		ATTACHING PARTS				
-182	AN364-832NC2	. . NUT	A,M,	P		16
-183	AN515-8-7	. . SCREW	A,M,	P		16

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -184	22-92395	. FITTING ASSEMBLY, CABLE BELT RIVETED -V83115-	A-L,	P		4
-185	30-93802-203	. PLATE, PASSENGER SEAT BASE NYLON -V83115- ATTACHING PARTS	A-L,	P		2
-186	NAS679A3	. NUT	A-L,	P		4
-187	AN509-10R8	. SCREW ----x----	A-L,	P		4
-188	22-92547-205	. PLATE, ENERGY ABSORBER -V83115- ATTACHING PARTS	A-L,	P		2
-189	NAS1403-5	. SCREW	A-L,	P		4
-190	NAS1403-6	. SCREW ----x----	A-L,	P		4
-191	22-92374-851	. CABLE ASSEMBLY, SEAT BELT INBD AND OUTBD SWAGED -V83115-	A-L,	P		2
-192	22-92547-203	. PLATE, ENERGY ABSORBER -V83115- ATTACHING PARTS	A-L,	P		1
-193	NAS679A3	. NUT	A-L,	P		2
-194	AN526-1032R7	. SCREW ----x----	A-L,	P		2
-195	22-92374-853	. CABLE ASSEMBLY, SEAT BELT CENTER SWAGED -V83115-	A-L,	P		2
-196	30-93571-7	. YOKE, SEAT BELT BOLT ATTACH -V83115-	M-N,	Q-R		4
-197	AN380-3-2	. PIN, COTTER	M-N,	Q-R		2
-198	AN960D516	. WASHER	M-N,	Q-R		2
-199	MS20392-4-35	. PIN, CLEVIS	M-N,	Q-R		2
-200	22-92392-7	. ROLLER, ENERGY ABSORBER -V83115-	M-N,	Q-R		2
-201	30-93570-7	. SUPPORT, ENERGY ABSORBER ROLLER INBD LH -V83115-	M-N,	Q-R		1
-202	30-93570-8	. SUPPORT, ENERGY ABSORBER ROLLER OUTBD RH -V83115- ATTACHING PARTS	MON,	Q-R		1
-203	NAS1403-5	. SCREW	M-N,	Q-R		4
-204	NAS1403-6	. SCREW ----x----	M-N,	Q-R		4
-205	22-92389-201	. SEAL, ENERGY ABSORBER DUST -V83115-	M-N,	Q-R		2
-206	22-92543-851	. ABSORBER ASSEMBLY, INBD AND OUTBD WELDED -V83115-	M-N,	Q-R		2
-207	22-92547-203	. PLATE, ENERGY ABSORBER -V83115- ATTACHING PARTS	M-N,	Q-R		1
-208	AN526-1032R10	. SCREW	M-N,	Q-R		2
-209	22-92389-203	. SEAL, ENERGY ABSORBER DUST -V83115- ----x----	M-N,	Q-R		1
-210	22-92542-851	. ABSORBER ASSEMBLY, CENTER WELDED -V83115-	M-N,	Q-R		1
-211	31-92510-203	. SOCKET ASSEMBLY, NYLON FRONT -V83115- ATTACHING PARTS	A-R			1
-212	AN526-1032R6	. SCREW	A-R			4
-213	AN960D10L	. WASHER	A-L,	P		4
-214	NAS679A3	. NUT ----x----	A-L,	P		4
-215	31-92510-207	. SOCKET ASSEMBLY, NYLON REAR -V83115- ATTACHING PARTS	A-R			1
-216	AN526-1032R7	. SCREW ----x----	A-R			2
-217	31-92510-1	. BASE ASSEMBLY, DOUBLE COACH PASSENGER SEAT LH -V83115-	D,F			1
	31-92510-801	. BASE ASSEMBLY, DOUBLE COACH PASSENGER SEAT LH -V83115-	B			1
	31-92510-851	. BASE ASSEMBLY, DOUBLE COACH PASSENGER SEAT LH -V83115-	H,M-	R		1
	31-92510-2	. BASE ASSEMBLY, DOUBLE COACH PASSENGER SEAT RH -V83115-	E			1
	31-92510-802	. BASE ASSEMBLY, DOUBLE COACH PASSENGER SEAT RH -V83115-	A,C			1
	31-92510-852	. BASE ASSEMBLY, DOUBLE COACH PASSENGER SEAT RH-V83115-	G,J-	L		1
-218	NAS77-5-100	. . BUSHING	A-R			4
-219	22-92520-9	. . PIVOT, SEAT BACK ATTACHMENT INBD -V83115-	A-R			1
-220	22-92519-205	. . PIVOT, SEAT BACK ATTACHMENT OUTBD -V83115-	A-R			1
-221	22-92519-203	. . PIVOT, SEAT BACK ATTACHMENT CENTER -V83115-	A-R			1
-222	30-93802-7	. . STRIP, SEAT BASE NYLON RIVETED -V83115-	A-R			1
-223	30-93560-7	. . RAIL, SIDE FITTING FWD LH -V83115-	B,D,	F,H,	M-R	1
	30-93560-8	. . RAIL, SIDE FITTING FWD RH -V83115- ATTACHING PARTS	A,C,	E,G,	J-L	1
-224	NAS1291-3	. . NUT	A-R			4
-225	AN960-10L	. . WASHER	A-R			4
-226	NAS1203-5	. . BOLT	A-R			2
-227	NAS1203-7	. . BOLT	A-R			2

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 -		----x----				
	AN380-1-1	. . PIN, COTTER	A-R			1
-228	AN392-60	. . PIN, FLAT HEAD	A-R			1
-229	30-93558-7	. . CAM, PASSENGER SEAT ANTI-RATTLE -V83115-	A-R			1
-230	22-92353-13	. . BEAD, SEAT PAN RUBBER -V83115-	A-R			2
-231	22-92516-7	. . PAN, PASSENGER SEAT -V83115-	A-R			2
		ATTACHING PARTS				
-232	AN526-1032-5	. . SCREW	A-R			8
		----x----				
	AN380-2-4	. . PIN, COTTER	A-R			4
-233	22-92546-7	. . TUBE, ENERGY ABSORBER -V83115-	A-R			1
-234	22-92546-11	. . TUBE, ENERGY ABSORBER -V83115-	A-R			1
-235	22-92531-15	. . FAIRING, FRAME FRONT RIVETED -V83115-	A-R			1
-236	22-92353-7	. . BEAD, FAIRING RUBBER V83115-	A-R			1
	30-93562-1	. . PIN ASSEMBLY, PASSENGER SEAT AFT SIDE -V83115-	A-R			1
-237	30-93561-7	. . . RING, SPLIT -V83115-	A-R			1
-238	30-93563-7	. . . SPRING, COMPRESSION -V83115-	A-R			1
-239	30-93564-7	. . . PIN, PASSENGER SEAT AFT SIDE -V83115-	A-R			1
-240	30-93533-7	. . RAIL, SIDE FITTING AFT LH RIVETED -V83115-	B,D,	F,H,	M-R	1
	30-93533-8	. . RAIL, SIDE FITTING AFT RH RIVETED -V83115-	A,C,	E, ,	J-L	1
-241	NAS1291-3	. . NUT	A-R			3
-242	NAS1103-3	. . BOLT	A-R			3
-243	22-92360-7	. . CLIP, ELASTIC CORD RIVETED -V83115-	A-R			4
-244	22-92518-7	. . STOP, FOOD TRAY -V83115-	A-R			2
-245	22-92518-201	. . STOP, FOOD TRAY -V83115-	A-R			1
-246	22-92518-202	. . STOP, FOOD TRAY -V83115-	A-R			1
		ATTACHING PARTS				
-247	NAS1103-2	. . BOLT	A-R			8
-248	AN960D10L	. . WASHER	A-R			8
		----x----				
-249	31-92518-851	. . LEG ASSEMBLY, PASSENGER SEAT LH RIVETED -V83115-	B,D,	F,H,	M-R	1
	31-92518-852	. . LEG ASSEMBLY, PASSENGER SEAT RH RIVETED -V83115-	A,C,	E,G,	J-L	1
		ATTACHING PARTS				
-250	NAS1103-2	. . BOLT	A-R			3
-251	NAS1104-3	. . BOLT	A-R			2
-252	MS20004-4	. . BOLT	A-R			2

SEE IPC PAGE 21 FOR USAGE CODE EXPLANATION

EXPLANATION OF IPC USAGE CODE

CODE	ASSEMBLY P/N	TITLE	CUSTOMER MODEL NO.	CUSTOMER
A=	31-92503-4	RH Double Coach	22(M)-4-1	CAT
B=	31-92503-809	LH Double Coach	22(M)-4-1	CAT
C=	31-92503-810	RH Double Coach	22(M)-4-1	CAT
D=	31-92503-803	LH Double Coach	22(M)-22-1 thru -5	JAL
E=	31-92503-804	RH Double Coach	22(M)-21-1 thru -5	JAL
F=	31-92503-1	LH Double Coach	30-6-3 thru -9	SWISSAIR
F=	31-92503-1	LH Double Coach	30-6-1 thru -2	
G=	30-94551-858	RH Double Coach		
H=	30-94551-861	LH Double Coach		
J=	30-94551-862	RH Double Coach		
K=	30-94551-852	RH Double Coach	22(M)-3-5	CATHAY
K=	30-94551-852	RH Double Coach	22(M)-3-1,-2,-3,-4,-6,-7	
L=	30-94551-864	RH Double Coach	22(M)-3-5	CATHAY
L=	30-94551-864	RH Double Coach	22(M)-3-1,-2,-3,-4,-6,-7	
M=	30-94551-853	LH Double Coach		
N=	30-94551-855	LH Double Coach		
P=	30-94551-867	LH Double Coach	30-8-1 thru -3	VARIG
Q=	30-94551-859	LH Double Coach	30-5-5 thru -24	AAL
Q=	30-94551-859	LH Double Coach	30-5-1,-2,-3,-4,-25	
R=	30-94551-865	LH Double Coach	30-5-5 thru -24	AAL
R=	30-94551-865	LH Double Coach	30-5-1,-2,-3,-4,-25	

ILLUSTRATED PARTS BREAKDOWN

PASSENGER SEAT ASSEMBLIES - TRIPLE

(Convair Part No.s 30-94550 and 31-92504 Series)

ATA NO. 25-2-33

Applicable to Models 22(M)-3, 22(M)-4, 22(M)-22, 30-5, 30-6, and 30-8

May 31/62

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25-2-33	IPC 19	May 31/62	D
25-2-33	IPC 20	May 31/62	D
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25-2-33	IPC 22	May 31/62	D
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AN364-1032		1 - 187	1
AN364-624		1 - 82	3
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AN380-2-4		1	8
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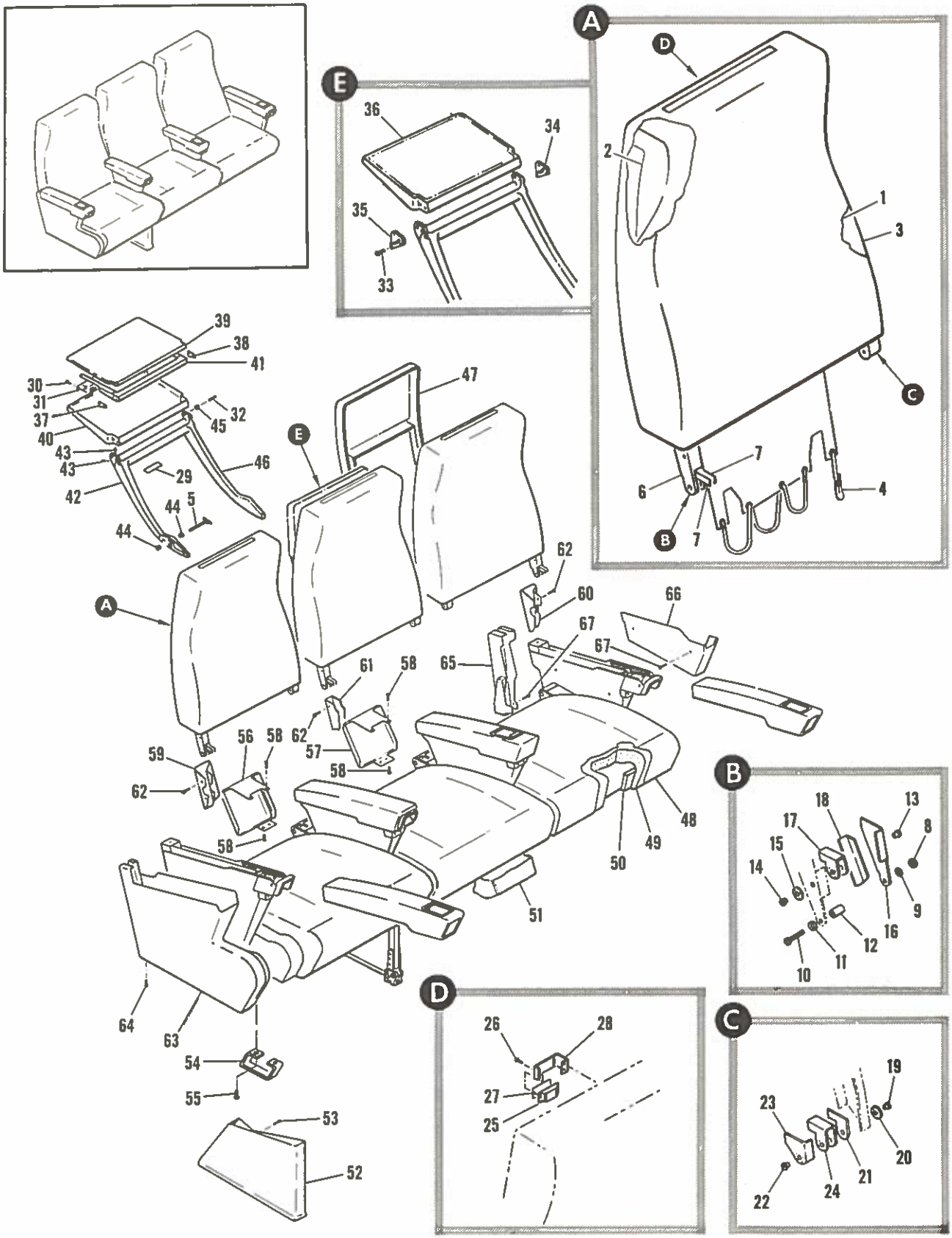
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NAS679A3		1 - 69	
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NAS679A5		1 - 8	1
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NAS75-4-010		1 - 204	6
NAS77-4-20		1 - 203	6
NAS77-5-100		1 - 278	6
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SL3500-2		1	
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SL3500-3		1	
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22-92332-9		1 - 60	1
22-92337-803		1	2
22-92337-804		1	1
22-92337-805		1	2
22-92337-806		1	1
22-92337-807		1	2
22-92337-808		1	1
22-92337-819		1	2
22-92337-820		1	1
22-92352-7		1 - 12	1
22-92352-9		1 - 76	1
22-92353-13		1 - 290	3
22-92353-7		1 - 298	1
22-92355		1 - 32	4
22-92356		1 - 78	1
22-92356-7		1 - 80	1
22-92357		1 - 79	1
22-92358-7		1 - 75	1
22-92360-7		1 - 305	6
22-92361-5		1 - 47	
		1	3
22-92371-7		1 - 37	1
22-92371-8		1 - 38	1
22-92374-851		1 - 249	2
22-92374-853		1 - 253	4
22-92379-1		1 - 3	3
22-92381-801		1 - 1	3
22-92381-809		1	3
22-92381-815		1	3
22-92381-823		1	3
22-92382-1		1 - 2	3
22-92389-201		1 - 263	2
22-92389-203		1 - 267	2
22-92392-7		1 - 258	2
22-92395		1 - 242	6
22-92411-7		1 - 151	1
22-92412-7		1 - 150	1
22-92413-7		1 - 146	1
22-92414-7		1	1
22-92414-9		1	1
22-92415-7		1 - 169	1
22-92416-7		1 - 170	1
22-92417-7		1 - 167	1
22-92418-7		1	1
22-92419-7		1 - 217	4
22-92419-9		1 - 218	1
22-92420-7		1 - 205	6
22-92421-7		1 - 164	1
22-92422-7		1 - 162	1
22-92425-201		1	3
22-92425-205		1	3
22-92425-207		1 - 29	3
22-92516-7		1 - 291	3
22-92518-201		1 - 307	2
22-92518-202		1 - 306	1
22-92518-7		1 - 308	3
22-92519-203		1 - 281	2
22-92519-205		1 - 279	1
22-92520-9		1 - 280	1
22-92531-17		1 - 297	1
22-92536		1 - 86	3
22-92538-201		1 - 111	1
22-92538-203		1 - 109	1
22-92538-851		1 - 108	3
22-92539-1		1 - 89	1
22-92539-7		1 - 100	1
22-92540-801		1	1
22-92542-851		1 - 268	2
22-92543-851		1 - 264	2
22-92546-11		1 - 294	1
22-92546-13		1 - 293	1
22-92546-7		1 - 295	2

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
22-92547-203		1 - 250	
		1 - 265	4
22-92547-205		1 - 246	2
22-92550-801		1	
		1	5
22-92550-811		1	3
22-92550-813		1	3
22-92551-201		1	1
22-92551-3		1 - 42	1
22-92551-9		1 - 46	1
22-92552-801		1 - 36	1
22-92552-807		1	1
22-92554-21		1 - 39	1
22-92554-25		1 - 40	1
22-92554-29		1	1
22-92555-1		1 - 41	1
22-92557-201		1 - 28	1
22-92558-13		1 - 49	3
22-92559-203		1 - 50	3
22-92567-210		1 - 240	1
22-92567-211		1 - 239	1
22-92567-213		1 - 241	1
22-92567-218		1	1
22-92568-10		1 -	1
22-92568-11		1 - 15	
		1 - 20	2
22-92568-13		1 - 17	
		1 - 24	2
22-92568-15		1 - 23	1
22-92568-16		1	1
22-92568-17		1 - 11	1
22-92568-7		1 - 16	1
22-92568-8		1	1
22-92568-9		1 - 18	1
22-92569-17		1	4
22-92569-23		1 - 27	2
22-92569-25		1 - 21	1
22-92587-5		1	1
22-92587-803		1 - 68	
		1	5
22-92589		1	1
22-92589-201		1 - 74	
		1	2
22-92596-803		1 - 4	
		1	4
22-92598-7		1 - 96	
		1 - 106	
		1 - 134	6
22-92599		1 - 54	1
22-93690-9		1	3
22-93698-17		1 - 48	3
22-93698-803		1	3
22-94502-9		1 - 7	2
22-94503-11		1 - 140	1
22-94503-215		1 - 121	2
22-94504-201		1 - 120	2
22-94506-3		1	1
22-94506-4		1	2
22-94507-1		1	1
22-94507-2		1	1
22-94510		1 - 158	
		1	3
22-94516		1	3
22-94517-9		1	6
22-94526-11		1 - 77	1
295202-413		1 - 171	3
30-93504-5		1	3
30-93523-7		1 - 202	6
30-93525-7		1 - 210	6
30-93527-7		1 - 219	6
30-93531-7		1 - 207	1
30-93531-9		1 - 206	6
30-93533-7		1 - 302	1
30-93533-8		1	1
30-93534-7		1 - 211	6

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
30-93555-1		1	2
30-93555-859		1 - 122	2
30-93555-863		1 - 163	1
30-93555-865		1 - 145	1
30-93558-7		1 - 289	1
30-93560-7		1 - 283	1
30-93560-8		1	1
30-93561-7		1 - 299	1
30-93562-1		1	1
30-93563-7		1 - 300	1
30-93564-7		1 - 301	1
30-93565-5		1 - 225	2
30-93565-801		1 - 224	1
30-93566-19		1 - 230	1
30-93566-205		1 - 232	1
30-93566-207		1 - 233	2
20-92466-21		1 - 231	2
30-93567-15		1 - 227	2
30-93567-17		1 - 226	1
30-93567-27		1 - 228	1
30-93567-29		1 - 229	2
30-93567-3		1 - 195	1
30-93567-5		1 - 194	1
30-93570-7		1 - 259	1
30-93570-8		1 - 260	1
30-93571-7		1 - 254	6
30-93801-7		1 - 34	1
30-93801-8		1 - 35	1
30-93802-203		1 - 243	2
30-93802-7		1 - 282	2
30-94520-3		1 - 172	1
30-94520-4		1	1
30-94520-5		1	1
30-94520-6		1	1
30-94520-7		1 - 177	1
30-94520-803		1	1
30-93520-804		1	1
30-94521-7		1 - 193	1
30-94522-7		1 - 189	1
30-94523-7		1 - 191	1
20-94524-7		1 - 190	1
30-94525-7		1 - 192	1
30-94527-7		1 - 183	1
30-94527-8		1	1
30-94528-201		1 - 180	1
30-94529-7		1 - 179	1
30-94530-7		1 - 181	1
30-94531-9		1 - 182	1
30-94550-851		1	13
30-94550-853		1	11
30-94550-855		1	1
30-94550-857		1	1
30-94550-860		1	6
30-94550-862		1	1
30-94550-864		1	6
30-94550-866		1	1
30-94550-868		1	14
31-92321-1		1 - 97	1
31-92321-15		1	1
31-92321-3		1 - 107	1
31-92321-5		1 - 135	1
31-92321-803		1	1
31-92323-11		1	1
31-92323-15		1 - 102	1
31-92323-17		1 - 130	1
31-92323-19		1 - 132	2
31-92323-201		1	
		1	2
31-92323-203		1	1
31-92323-205		1 - 94	2
31-92323-21		1 - 91	1
31-92323-23		1 - 93	2
31-92323-25		1	2
31-92323-27		1	1
31-92323-29		1	1
31-92323-3		1 - 98	1

PART NUMBER	CHAPTER AND SUBJECT	FIGURE AND INDEX NUMBER	QTY. PER ACFT.
31-92323-31		1	2
31-92323-5		1 - 128	1
31-92323-7		1 - 104	2
31-92323-801		1 - 87	2
31-92323-803		1	1
31-92323-805		1	2
31-92323-851		1	2
31-92323-853		1	1
31-92323-855		1	1
31-92330-1		1 - 63	1
31-92330-2		1	1
31-92330-201		1 - 66	1
31-92330-202		1	1
31-92330-203		1 - 65	1
31-92330-204		1	1
31-92330-205		1 - 153	1
31-92330-803		1 - 52	1
31-92330-804		1	1
31-92380-11		1 - 131	1
31-92380-13		1 - 92	1
31-92380-15		1	1
31-92380-17		1	1
31-92380-201		1	
		1	2
31-92380-203		1	1
31-92380-9		1 - 103	1
31-92504-2		1	13
31-92504-3		1	9
31-92504-805		1	14
31-92504-813		1	1
31-92505-9		1 - 81	3
31-92510-201		1 - 269	1
31-92510-202		1 - 270	1
31-92510-205		1 - 274	1
31-92510-206		1 - 275	1
31-92510-3		1 - 277	1
31-92510-5		1	1
31-92510-803		1	1
31-92510-853		1	1
31-92510-854		1	1
31-92518-1		1 - 311	1
31-92518-2		1	1
31-92554-10		1	1
31-92554-7		1 - 57	1
31-92554-9		1 - 56	1
31-92560-1		1 - 6	2
31-92560-2		1	1
31-92570-3		1	1
31-92570-4		1 - 124	1
31-92570-5		1 - 123	1
31-92570-6		1	1
31-92570-803		1	1
31-92570-804		1	1
31-92570-808		1	1
31-92570-809		1	1
31-92582-7		1	1
31-92582-8		1	1
31-92591-5		1	1
31-92591-6		1 - 152	1
31-92593-201		1 - 138	1
31-92593-9		1 - 118	2
31-92595-3		1	1
31-92595-4		1 - 127	1
31-92595-5		1	1
31-92595-6		1 - 136	1
31-92595-7		1 - 137	
31-92595-802		1	1
31-92596-7		1 - 147	1
31-93302-1		1 - 51	3
51-30150		1 - 148	
		1 - 216	6
5133-25		1 - 119	
		1 - 139	5
52NKTE048		1 - 220	
		1 - 199	8


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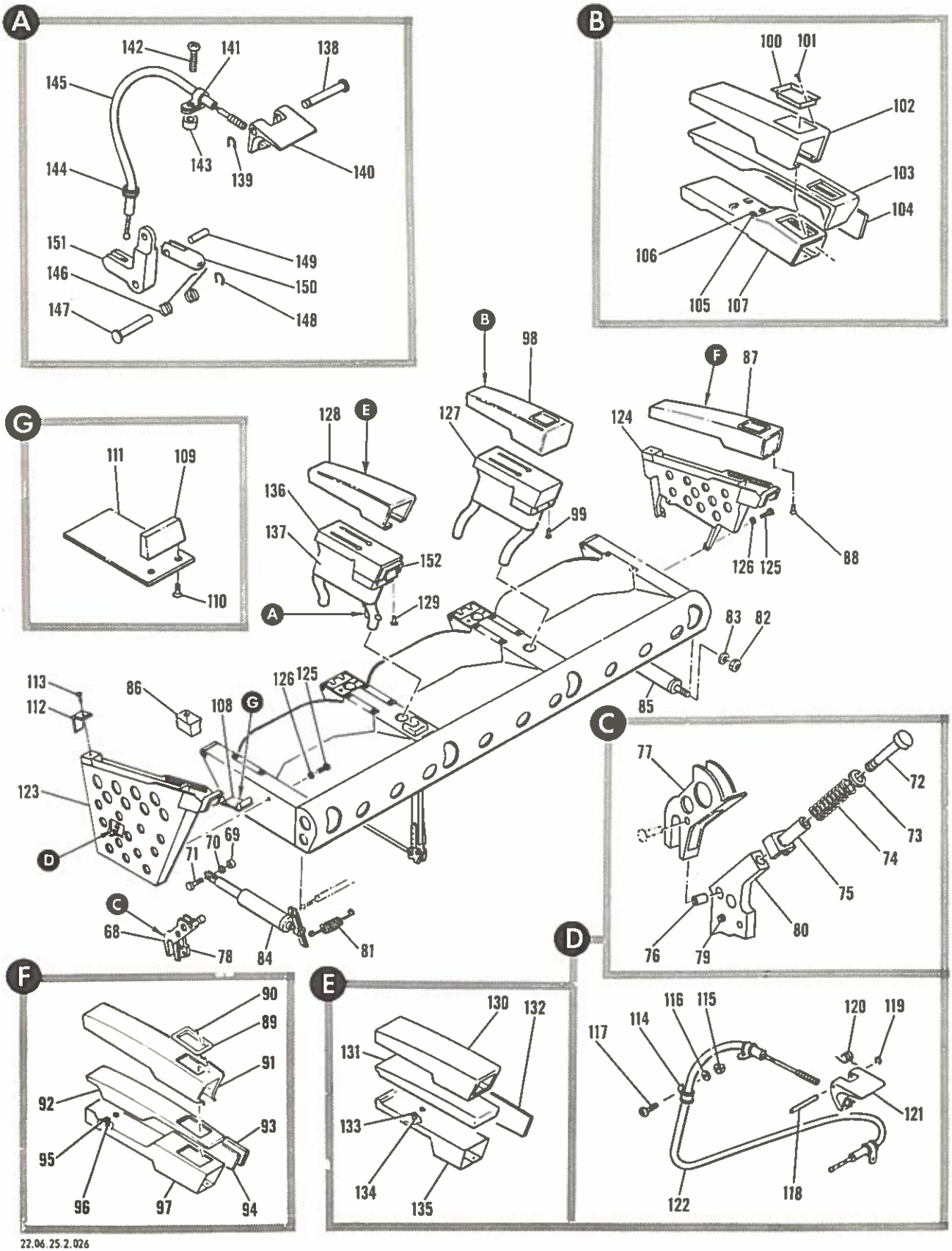
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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	31-92504-3	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	A			9
	31-92504-813	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	B			1
	31-92504-805	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	C			14
	31-92504-2	SEAT ASSEMBLY, TRIPLE COACH PASSENGER RH -V83115-	D			13
	30-94550-853	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	E			11
	30-94550-855	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	F			1
	30-94550-851	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	G			13
	30-94550-857	SEAT ASSEMBLY, TRIPLE COACH PASSENGER LH -V83115-	H			1
	30-94550-860	SEAT ASSEMBLY, TRIPLE COACH PASSENGER RH -V83115-	J			6
	30-94550-862	SEAT ASSEMBLY, TRIPLE COACH PASSENGER RH -V83115-	K			1
	30-94550-864	SEAT ASSEMBLY, TRIPLE COACH PASSENGER RH -V83115-	L			6
	30-94550-866	SEAT ASSEMBLY, TRIPLE COACH PASSENGER RH -V83115-	M			1
	30-94550-868	SEAT ASSEMBLY, TRIPLE COACH PASSENGER RH -V83115-	N			14
	22-92337-805	. BACK ASSEMBLY, INBD AND CENTER -V83115-	A-B			2
	22-92337-806	. BACK ASSEMBLY, OUTBD -V83115-	A-B			1
	22-92337-819	. BACK ASSEMBLY, INBD AND CENTER -V83115-	C			2
	22-92337-820	. BACK ASSEMBLY, OUTBD -V83115-	C			1
	22-92337-803	. BACK ASSEMBLY, INBD AND CENTER -V83115-	D			2
	22-92337-804	. BACK ASSEMBLY, OUTBD -V83115-	D			1
	22-92337-804	. BACK ASSEMBLY, INBD AND CENTER -V83115-	E-N			2
	22-92337-808	. BACK ASSEMBLY, OUTBD -V83115-	E-N			1
- 1	22-92381-801	. COVER ASSEMBLY, TRIPLE COACH SEAT BACK -V83115-	A-B			3
	22-92381-823	. COVER ASSEMBLY, TRIPLE COACH SEAT BACK -V83115-	C			3
	22-92381-809	. COVER ASSEMBLY, TRIPLE COACH SEAT BACK -V83115-	D			3
	22-92381-815	. COVER ASSEMBLY, TRIPLE COACH SEAT BACK -V83115-	E-N			3
- 2	22-92382-1	. PILLOW ASSEMBLY, PASSENGER SEAT HEADREST BONDED -V83115-	A-B			3
- 3	22-92379-1	. CUSHION ASSEMBLY, SEAT BACK BONDED -V83115-	A-B			3
	30-93504-5	. CUSHION ASSEMBLY, SEAT BACK BONDED -V83115-	C-N			3
- 4	22-92596-803	. CORD, SEAT BACK ELASTIC -V83115-	A-B,	D		3
	22-92596-803	. CORD, SEAT BACK ELASTIC -V83115-	C,E-	N		1
- 5	NAS1335A2C33	. PIN, QUICK DISCONNECT	A-N			6
- 6	31-92560-1	. BACK ASSEMBLY, STRUCTURE INBD AND CENTER -V83115-	A-N			2
	31-92560-2	. BACK ASSEMBLY, STRUCTURE OUTBD -V83115-	A-N			1
- 7	22-94502-9	. . GUIDE, SEAT BACK -V83115-	A-N			2
- 8	NAS679A5	. . NUT	A-N			1
- 9	AN960D516L	. . WASHER	A-N			1
- 10	NAS1205-18	. . BOLT	A-N			1
- 11	22-92568-17	. . WASHER, SEAT BACK -V83115-	A-N			1
- 12	22-92352-7	. . SPACER, MECHANISM ATTACH BACK -V83115-	A-N			1
- 13	NAS77-5-20	. . BUSHING	A-N			1
- 14	NAS77-5-27	. . BUSHING	A-N			1
- 15	22-92568-11	. . WASHER, SEAT BACK -V83115-	A-N			1
- 16	22-92568-7	. . ANGLE, SEAT BACK INBD AND CENTER -V83115-	A-N			1
	22-92568-8	. . ANGLE, SEAT BACK OUTBD -V83115-	A-N			1
- 17	22-92568-13	. . CHANNEL, SEAT BACK -V83115-	A-N			1
- 18	22-92568-9	. . CLIP, SEAT BACK INBD AND CENTER -V83115-	A-N			1
	22-92568-10	. . CLIP, SEAT BACK OUTBD -V83115-	A-N			1
		SEE PAGE 25 FOR CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 19	NAS77-5-22	. . BUSHING	A-N			1
- 20	22-92568-11	. . WASHER, SEAT BACK -V83115-	A-N			1
- 21	22-92569-25	. . SHIM, SEAT BACK -V83115-	A-N			1
- 22	NAS77-5-20	. . BUSHING	A-N			1
- 23	22-92568-15	. . ANGLE, SEAT BACK INBD AND CENTER -V83115-	A-N			1
	22-92568-16	. . ANGLE, SEAT BACK OUTBD -V83115-	A-N			1
- 24	22-92568-13	. . CHANNEL, SEAT BACK -V83115-	A-N			1
- 25	H311-11	. . LATCH, FOOD TRAY -V83015- ATTACHING PARTS	A-N			1
- 26	NAS623-2-3	. . SCREW	A-N			2
- 27	22-92569-23	. . SHIM, SEAT BACK -V83115- ----x----	A-N			2
- 28	22-92557-201	. . BRACKET, FOOD TRAY LATCH -V83115-	A-N			1
- 29	22-92425-207	. PLACARD, LIFE VEST STOWAGE -V83115-	C			3
	22-92425-201	. PLACARD, LIFE VEST STOWAGE -V83115-	D-F			3
	22-92425-205	. PLACARD, LIFE VEST STOWAGE -V83115-	N			3
	22-92550-801	. TRAY INSTALLATION, FOOD -V83115-	A,C,	E,G,	J,N	3
	22-92550-801	. TRAY INSTALLATION, FOOD -V83115-	B,F			2
	22-92550-811	. TRAY INSTALLATION, FOOD -V83115-	L			3
	22-92550-813	. TRAY INSTALLATION, FOOD -V83115-	D			3
- 30	AN507DD1032R6	. . SCREW	A-G,	J,L,	N	3
- 31	H311-17	. . LATCH, CONVAIR 95-51300-008 -V83015-	A-B			1
	H311-21	. . LATCH, CONVAIR 95-51300-010 -V83015-	C-G,	J,L,	N	1
- 32	22-92355	. . SCREW, TABLE TRAY PIVOT -V83115-	A-G,	J,L,	N	4
- 33	AN507-440R6	. . SCREW	L			6
- 34	30-93801-7	. . PLATE, FOOD TRAY TABLE FRICTION LH -V83115-	L			1
- 35	30-93801-8	. . PLATE, FOOD TRAY TABLE FRICTION RH -V83115-	L			1
- 36	22-92552-801	. . TABLE ASSEMBLY, FOOD TRAY -V83115-	A-C, L,N	E-G,	J,	1
	22-92552-807	. . TABLE ASSEMBLY, FOOD TRAY -V83115-	D			1
- 37	22-92371-7	. . . SPACER, FOOD TRAY PIVOT LH -V83115-	A-G,	J,L,	N	1
- 38	22-92371-8	. . . SPACER, FOOD TRAY PIVOT RH -V83115-	A-G,	J,L,	N	1
- 39	22-92554-21	. . . SHELL, FOOD TRAY BONDED -V83115-	A-C, L,N	E-G,	J,	1
	22-92554-29	. . . SHELL, FOOD TRAY BONDED -V83115-	D			1
- 40	22-92554-25	. . . SHELL ASSEMBLY, FOOD TRAY BONDED -V83115-	A-G,	J,L,	N	1
- 41	22-92555-1	. . . STRUCTURE ASSEMBLY, TRAY TABLE RIVETED -V83115-	A-G,	J,L,	N	1
- 42	22-92551-3	. . SUPPORT ASSEMBLY, TRAY TABLE -V83115-	A-G,	J,N		1
	22-92551-201	. . SUPPORT ASSEMBLY, TRAY TABLE -V83115-	L			1
- 43	AN565D1032H3	. . . SCREW	A-G,	J,L,	N	4
- 44	NAS77-5-38	. . . BUSHING	A-G,	J,L,	N	4
- 45	NAS75-3-016	. . . BUSHING	A-G,	J,L,	N	2
- 46	22-92551-9	. . . SUPPORT, -V83115-	A-G,	J,L,	N	1
- 47	22-92361-5	. FAIRING ASSEMBLY, INBD FOOD TRAY DUMMY RIVETED -V83115-	B,F			1
	22-92361-5	. FAIRING ASSEMBLY, INBD AND CENTER FOOD TRAY DUMMY RIVETED -V83115-	H,K,	M		2
	22-93698-803	. CUSHION ASSEMBLY, INBD, CENTER AND OUTBD BOTTOM -V83115-	A-N			3
- 48	22-93698-17	. COVER, INBD, CENTER AND OUTBD SEAT BOTTOM -V83115-	A-N			3
	22-93698-9	. STRAP, BOTTOM COVER STITCHED -V83115-	A-N			3
- 49	22-92558-13	. CUSHION, SEAT BOTTOM FOAM -V83115-	A-N			3
- 50	22-92559-203	. PAD, BOTTOM CUSHION FOAM -V83115-	A-N			3
- 51	31-93302-1	. CONTAINER ASSEMBLY, LIFE VEST STITCHED -V83115-	A-F,	N		3
- 52	31-92330-803	. FAIRING ASSEMBLY, TRIPLE COACH SEAT LEG LH BONDED -V83115-	A-C,	E-H		1
	31-92330-804	. FAIRING ASSEMBLY, TRIPLE COACH SEAT LEG RH BONDED -V83115- ATTACHING PARTS	D,J-	N		1
- 53	AN526-1032R12	. SCREW ----x----	A-N			4
		SEE PAGE 25 FOR CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 54	22-92599	. STEP, TRIPLE COACH STEWARDESS -V83115-	J-N			1
		ATTACHING PARTS				
- 55	AN509-416R15	. SCREW	J-N			2
		----x----				
- 56	31-92554-9	. FAIRING, COACH SEAT CENTER HINGE INBD LH -V83115-	A-C,	E-H		1
	31-92554-10	. FAIRING, COACH SEAT CENTER HINGE INBD RH -V83115-	D,J-	N		1
- 57	31-92554-7	. FAIRING, COACH SEAT CENTER HINGE OUTBD -V83115-	A-N			1
		ATTACHING PARTS				
- 58	AN526-832R8	. SCREW	A-N			8
		----x----				
- 59	22-92332-13	. FAIRING, INBD BACK LH -V83115-	D,J-	N		1
	22-92332-14	. FAIRING, INBD BACK RH -V83115-	A-C,	E-H		1
- 60	22-92332-9	. FAIRING, OUTBD BACK LH -V83115-	D,J-	N		1
	22-92332-10	. FAIRING, OUTBD BACK RH - V83115-	A-C,	E-H		1
- 61	22-92332-11	. FAIRING, CENTER BACK -V83115-	A-N			1
		ATTACHING PARTS				
- 62	AN526-632R6	. SCREW	A-N			12
		----x----				
- 63	31-92330-1	. FAIRING ASSEMBLY, COACH SEAT INBD ARM LH BONDED -V83115-	A-C,	E-H		1
	31-92330-2	. FAIRING ASSEMBLY, COACH SEAT INBD ARM RH BONDED -V83115-	D,J-	N		1
		ATTACHING PARTS				
- 64	AN526-632R6	. SCREW	A-N			AR
		----x----				
- 65	31-92330-203	. FAIRING, COACH SEAT OUTBD ARM LH -V83115-	A-C,	E-H		1
	31-92330-204	. FAIRING, COACH SEAT OUTBD ARM RH -V83115-	D,J-	N		1
- 66	31-92330-201	. FAIRING, COACH SEAT OUTBD ARM LH -V83115-	A-C,	E-H		1
	31-92330-202	. FAIRING, COACH SEAT OUTBD ARM RH -V83115-	D,J-	N		1
		ATTACHING PARTS				
- 67	AN526-632R6	. SCREW	A-N			5

SEE PAGE 25 FOR CODE EXPLANATION


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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 68	22-92587-803	. BREAKOVER ASSEMBLY, SEAT BACK -V83115-	A-H,	N		3
	22-92587-5	. BREAKOVER ASSEMBLY, SEAT BACK INBD -V83115-	J-M			1
	22-92587-803	. BREAKOVER ASSEMBLY, SEAT BACK OUTBD AND CENTER -V83115- ATTACHING PARTS	J-M			2
- 69	NAS679A3	. NUT	A-N			3
- 70	AN960D10L	. WASHER	A-N			3
- 71	NAS1103-9	. BOLT ----x----	A-N			3
- 72	AN3-15A	. . BOLT	A-N			1
- 73	AN960D416	. . WASHER	A-N			1
- 74	22-92589-201	. . SPRING, BREAKOVER COMPRESSION -V83115-	A-H,	N		1
	22-92589	. . SPRING, BREAKOVER COMPRESSION INBD -V83115-	J-M			1
	22-92589-201	. . SPRING, BREAKOVER COMPRESSION OUTBD AND CENTER -V83115-	J-M			1
- 75	22-92358-7	. . STOP, BREAKOVER FITTING -V83115-	A-N			1
- 76	22-92352-9	. . SPACER, MECHANISM ATTACH BACK -V83115-	A-N			1
- 77	22-94526-11	. . YOKE, BREAKOVER FITTING -V83115-	A-N			1
- 78	22-92356	. . BLOCK ASSEMBLY, BREAKOVER -V83115-	A-N			1
- 79	22-92357	. . . PIN, BREAKOVER FITTING -V83115-	A-N			1
- 80	22-92356-7	. . . BLOCK, BREAKOVER FITTING -V83115-	A-N			1
- 81	31-92505-9	. SPRING, SEAT LOCK LEVER -V83115-	C-N			3
- 82	AN364-624	. NUT	A-N			3
- 83	AN960D616	. WASHER	A-N			AR
	22-94517-9	. SPRING, SEAT LOCK HELPER -V83115-	A-B			6
	AN380-2-2	. PIN, COTTER	A-B			3
	22-94516	. PIN, SEAT LOCK HELPER SPRING -V83115-	A-B			3
- 84	SL3500	. LOCK, SEAT POSITIONER INBD AND CENTER CONVAIR 96-93500-003 -V02953-	C			2
- 85	SL3500-1	. LOCK, SEAT POSITIONER OUTBD CONVAIR 96-93500-004 -V02953-	C			1
	SL3500	. LOCK, SEAT POSITIONER INBD CONVAIR 96-93500-003 -V02953-	D			1
	SL3500-1	. LOCK, SEAT POSITIONER CENTER AND OUTBD CONVAIR 96-93500-004 -V02953-	D			2
	SL3500-2	. LOCK, SEAT POSITIONER INBD AND CENTER CONVAIR 96-93500-010 -V02953-	E-H			2
	SL3500-3	. LOCK, SEAT POSITIONER OUTBD CONVAIR 96-93500-011 -V02953-	E-H			1
	SL3500-2	. LOCK, SEAT POSITIONER INBD CONVAIR 96-93500-010 -V02953-	J-N			1
	SL3500-3	. LOCK, SEAT POSITIONER CENTER AND OUTBD CONVAIR 96-93500-011 -V02953-	J-N			2
	L33-1037-00	. LOCK, SEAT POSITIONER INBD, CENTER AND OUTBD CONVAIR 96-93500-008 -V45402-	A-B			3
- 86	22-92536	. ASH TRAY ASSEMBLY, ARMCAP RIVETED -V83115-	A-B,	D-N		3
	22-94506-3	. ASH TRAY ASSEMBLY, ARMCAP -V83115-	C			1
	22-94506-4	. ASH TRAY ASSEMBLY, ARMCAP -V83115-	C			2
	22-92540-801	. . COVER AND ESCUTCHEON ASSEMBLY, RIVETED -V83115-	C			1
	22-94507-1	. . RECEIVER ASSEMBLY, ASH TRAY INBD RIVETED -V83115-	C			1
	22-94507-2	. . RECEIVER ASSEMBLY, ASH TRAY CENTER AND OUTBD RIVETED -V83115-	C			1
- 87	31-92323-801	. COVER ASSEMBLY, INBD AND OUTBD ARMREST -V83115-	A-B,	D-K,	N	2
	31-92323-851	. COVER ASSEMBLY, INBD AND OUTBD ARMREST -V83115-	L-M			2
	31-92323-805	. COVER ASSEMBLY, INBD AND OUTBD ARMREST -V83115- ATTACHING PARTS	C			2
- 88	AN526-1032R6	. SCREW ----x----	A-N			4
- 89	22-92539-1	. . ESCUTCHEON ASSEMBLY, ASH TRAY WELDED -V83115-	A-B,	D-N		1

SEE PAGE 25 FOR CODE EXPLANATION

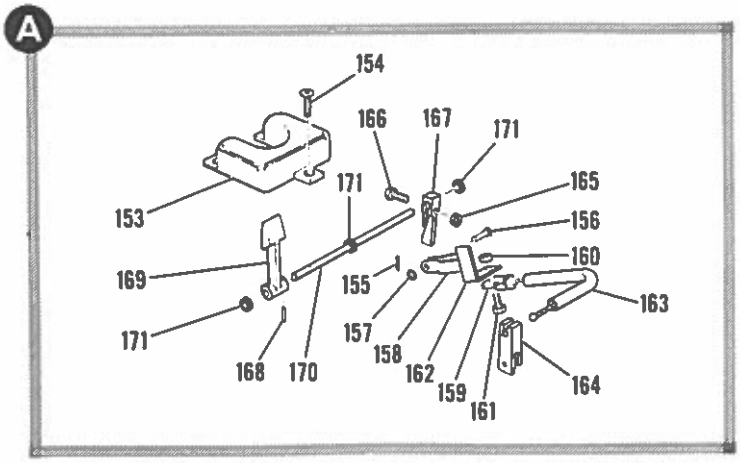
FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1		ATTACHING PARTS				
- 90	AN507-632R5	. . SCREW	A-B,	D-N		1
		----x----				
- 91	31-92323-21	. . COVER, ARMREST -V83115-	A-B,	D-K,	N	1
	31-92323-203	. . COVER, ARMREST -V83115-	L-M			1
	31-92323-29	. . COVER, ARMREST -V83115-	C			1
- 92	31-92380-13	. . PAD, ARMCAP TOP -V83115-	A-B,	D-K,	N	1
	31-92380-203	. . PAD, ARMCAP TOP -V83115-	L-M			1
	31-92380-17	. . PAD, ARMCAP TOP -V83115-	C			1
- 93	31-92323-23	. . PAD, ARMREST SIDE -V83115-	A-N			2
- 94	31-92323-205	. . PAD, ARMREST SIDE -V83115-	A-N			2
- 95	AN960-8L	. . WASHER	A-N			2
- 96	22-92598-7	. . PIN, ARMCAP -V83115-	A-N			2
- 97	31-92321-1	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	A-B,	D-N		1
	31-92321-803	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	C			1
- 98	31-92323-3	. COVER ASSEMBLY, OUTBD CENTER ARMREST -V83115-	A-B,	D-K,	N	1
	31-92323-853	. COVER ASSEMBLY, OUTBD CENTER ARMREST -V83115-	L-M			1
	31-92323-803	. COVER ASSEMBLY, OUTBD CENTER ARMREST -V83115-	C			1
		ATTACHING PARTS				
- 99	AN526-832R6	. SCREW	A-N			2
		----x----				
- 100	22-92539-7	. . ESCUTCHEON ASSEMBLY, ASH TRAY WELDED -V83115-	A-B,	D-N		1
		ATTACHING PARTS				
- 101	AN507-632R5	. . SCREW	A-B,	D-N		1
		----x----				
- 102	31-92323-15	. . COVER, ARMREST -V83115-	A-B,	D-K,	N	1
	31-92323-201	. . COVER, ARMREST -V83115-	L-M			1
	31-92323-27	. . COVER, ARMREST -V83115-	C			1
- 103	31-92380-9	. . PAD, ARMCAP TOP -V83115-	A-B,	D-K,	N	1
	31-92380-201	. . PAD, ARMCAP TOP -V83115-	L-M			1
	31-92380-15	. . PAD, ARMCAP TOP -V83115-	C			1
- 104	31-92323-7	. . PAD, ARMREST SIDE -V83115-	A-N			2
- 105	AN960-8L	. . WASHER	A-N			2
- 106	22-92598-7	. . PIN, ARMCAP -V83115-	A-N			2
	31-92582-7	. . GUIDE, NYLON COVER LH RIVETED -V83115-	A-B,	D-N		1
	31-92582-8	. . GUIDE, NYLON COVER RH RIVETED -V83115-	A-B,	D-N		1
	31-92323-25	. . SHIM, ARMREST RIVETED -V83115-	A-B,	D-N		2
	31-92323-11	. . CLIP, ARMREST RIVETED -V83115-	A-B,	D-N		1
- 107	31-92321-3	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	A-B,	D-N		1
	31-92321-15	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	C			1
	31-92323-31	. . BUMPER, ARMREST RUBBER -V83115-	C			2
- 108	22-92538-851	. COVER ASSEMBLY, ASH TRAY -V83115-	A-B,	D-N		3
- 109	22-92538-203	. . KNOB, ASH TRAY COVER -V83115-	A-B,	D-N		1
		ATTACHING PARTS				
- 110	AN507-440R3	. . SCREW	A-B,	D-N		2
		----x----				
- 111	22-92538-201	. . PLATE, ASH TRAY COVER -V83115-	A-B,	D-N		1
- 112	22-92315-13	. CAP ASSEMBLY, INBD AND OUTBD SCUFF WELDED -V83115-	A-N			2
		ATTACHING PARTS				
- 113	AN507-1032R7	. SCREW	A-N			2
		----x----				
- 114	MS21919DG4	. CLAMP	A-N			6
		ATTACHING PARTS				
- 115	NAS679A08	. NUT	A-N			6
- 116	AN960D8	. WASHER	A-N			6
- 117	AN526-832R8	. SCREW	A-N			6
		----x----				
		SEE PAGE 25 FOR CODE EXPLANATION				

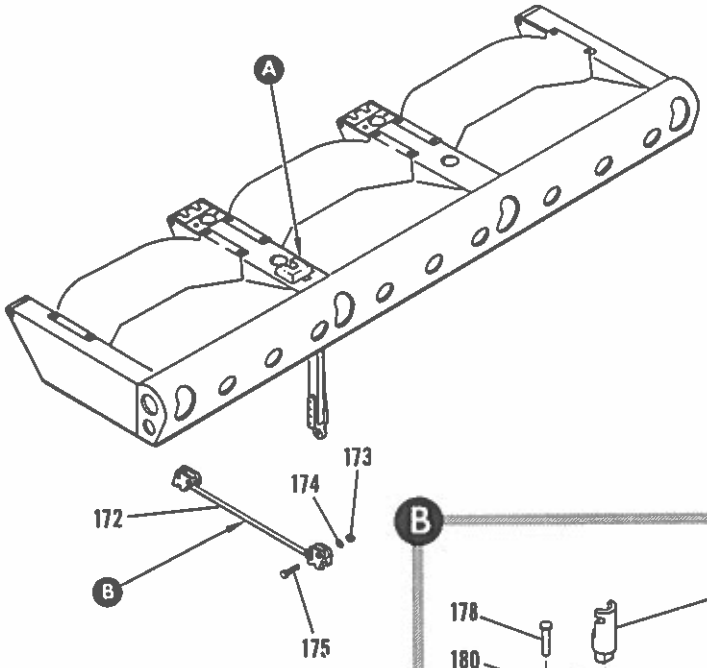
FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 118	31-92593-9	. PIN, RECLINE LEVER -V83115-	A-N			2
- 119	5133-25	. RING, EXTERNAL RETAINING CONVAIR 97-61504-004 -V79136-	A-N			4
- 120	22-94504-201	. SPRING, RECLINE LEVER -V83115-	A-N			2
- 121	22-94503-215	. LEVER ASSEMBLY, SEAT RECLINE RIVETED -V83115-	A-N			2
	MS20392-1-9	. PIN, CLEVIS	A-B			2
	AN960C4L	. WASHER	A-B			2
	22-94510	. FORK, RECLINE END -V83115-	A-B			2
- 122	30-93555-859	. CABLE ASSEMBLY, INBD AND OUTBD SEAT LOCK SWAGED -V83115-	A-B			2
	30-93555-1	. CABLE ASSEMBLY, INBD AND OUTBD SEAT LOCK SWAGED -V83115-	C-N			2
- 123	31-92570-5	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	A-B			1
	31-92570-809	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	C			1
	31-92570-803	. STRUCTURE ASSEMBLY, INBD ARMREST LH RIVETED -V83115-	E-H			1
	31-92570-6	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	D			1
	31-92570-804	. STRUCTURE ASSEMBLY, INBD ARMREST RH RIVETED -V83115-	J-N			1
- 124	31-92570-4	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	A-B,	E-H		1
	31-92570-808	. STRUCTURE ASSEMBLY, OUTBD ARMREST LH RIVETED -V83115-	C			1
	31-92570-3	. STRUCTURE ASSEMBLY, OUTBD ARMREST RH RIVETED -V83115- ATTACHING PARTS	D,J-	N		1
- 125	NAS1104-3	. BOLT	A-N			6
- 126	AN960D416L	. WASHER ----x----	A-N			6
- 127	31-92595-4	. ARMREST ASSEMBLY, OUTBD CENTER BONDED LH -V83115-	A-B,	E-H		1
	31-92595-802	. ARMREST ASSEMBLY, OUTBD CENTER BONDED LH -V83115-	C			1
	31-92595-3	. ARMREST ASSEMBLY, OUTBD CENTER BONDED RH -V83115-	D,J-	N		1
- 128	31-92323-5	. COVER ASSEMBLY, INBD CENTER ARMREST -V83115-	A-K,	N		1
	31-92323-855	. COVER ASSEMBLY, INBD CENTER ARMREST -V83115- ATTACHING PARTS	L-M			1
- 129	AN526-832R6	. SCREW ----x----	A-N			2
- 130	31-92323-17	. . COVER, ARMREST -V83115-	A-K,	N		1
	31-92323-201	. . COVER, ARMREST -V83115-	L-M			1
- 131	31-92380-11	. . PAD, ARMCAP TOP -V83115-	A-K,	N		1
	31-92380-201	. . PAD, ARMCAP TOP -V83115-	L-M			1
- 132	31-92323-19	. . PAD, ARMREST SIDE -V83115-	A-N			2
- 133	AN960-8L	. . WASHER	A-N			2
- 134	22-92598-7	. . PIN, ARMCAP -V83115-	A-N			2
- 135	31-92321-5	. . STRUCTURE ASSEMBLY, ARMCAP RIVETED -V83115-	A-N			1
- 136	31-92595-6	. ARMREST ASSEMBLY, INBD CENTER LH -V83115-	A-C,	E-H		1
	31-92595-5	. ARMREST ASSEMBLY, INBD CENTER RH -V83115-	D,J-	N		1
- 137	31-92595-7	. . TRIM, ARMREST BONDED -V83115-	A-N			AR
- 138	31-92593-201	. . PIN, RECLINE LEVER -V83115-	A-N			1
- 139	5133-25	. . RING, EXTERNAL RETAINING CONVAIR 97-61504-004 -V79136-	A-N			1
- 140	22-94503-11	. . LEVER, SEAT RECLINE -V83115-	A-N			1
- 141	AN742D4	. . CLAMP, SUPPORT CABLE ATTACHING PARTS	A-N			1
- 142	NAS220-9	. . SCREW	A-N			1
- 143	NAS42DD6-16	. . SPACER ----x----	A-N			1

SEE PAGE 25 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 144	AN931-4-7	. . GROMMET, ELASTIC	A-N			1
- 145	30-93555-865	. . CABLE ASSEMBLY, INBD CENTER ARMREST SWAGED -V83115-	A-N			1
- 146	22-92413-7	. . SPRING, TORSION RECLINE -V83115-	A-N			1
- 147	31-92596-7	. . PIN, CENTER ARMREST BELLCRANK -V83115-	A-N			1
- 148	5103-15	. . RING, RETAINING SNAP CONVAIR 97-61512-004 -V89462-	A-N			1
	AN380-2-1	. . PIN, COTTER	A-N			1
- 149	AN392-13	. . PIN, FLAT HEAD	A-N			1
- 150	22-92412-7	. . ROD, RECLINE MECHANISM PUSH -V83115-	A-N			1
- 151	22-92411-7	. . BELLCRANK, RECLINE MECHANISM -V83115-	A-N			1
- 152	31-92591-6	. . STRUCTURE ASSEMBLY, INBD CENTER ARMREST LH RIVETED -V83115-	A-C,	E-H		1
	31-92591-5	. . STRUCTURE ASSEMBLY, INBD CENTER ARMREST RH RIVETED -V83115-	D,J-	N		1

SEE PAGE 25 FOR CODE EXPLANATION


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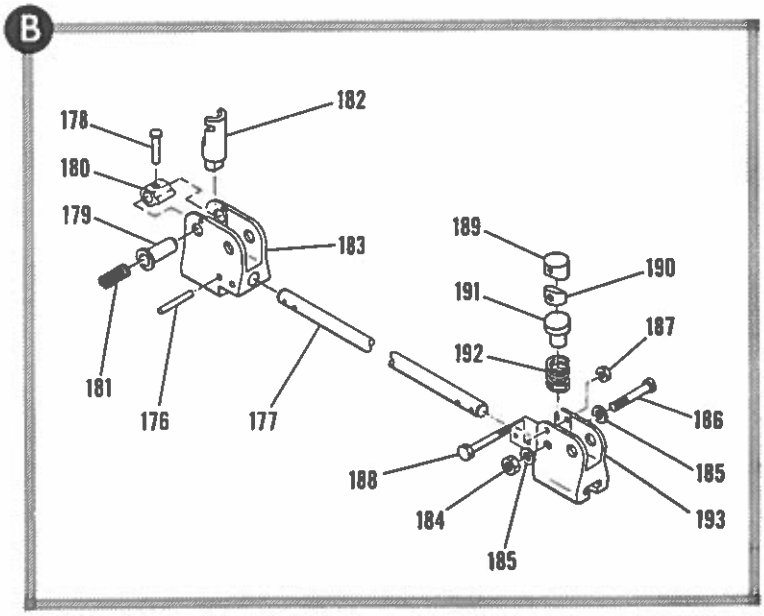
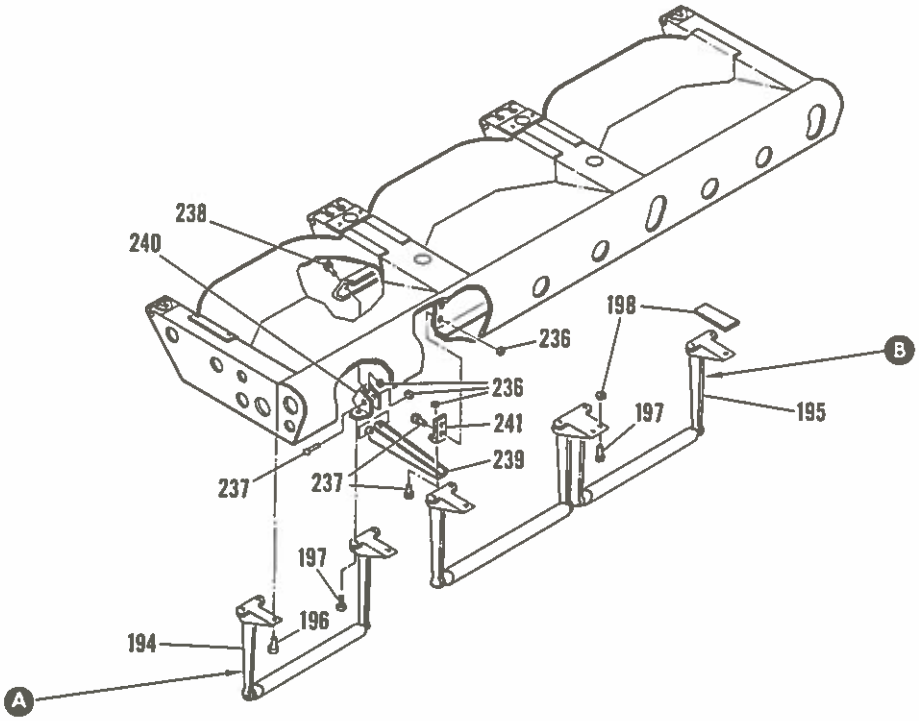
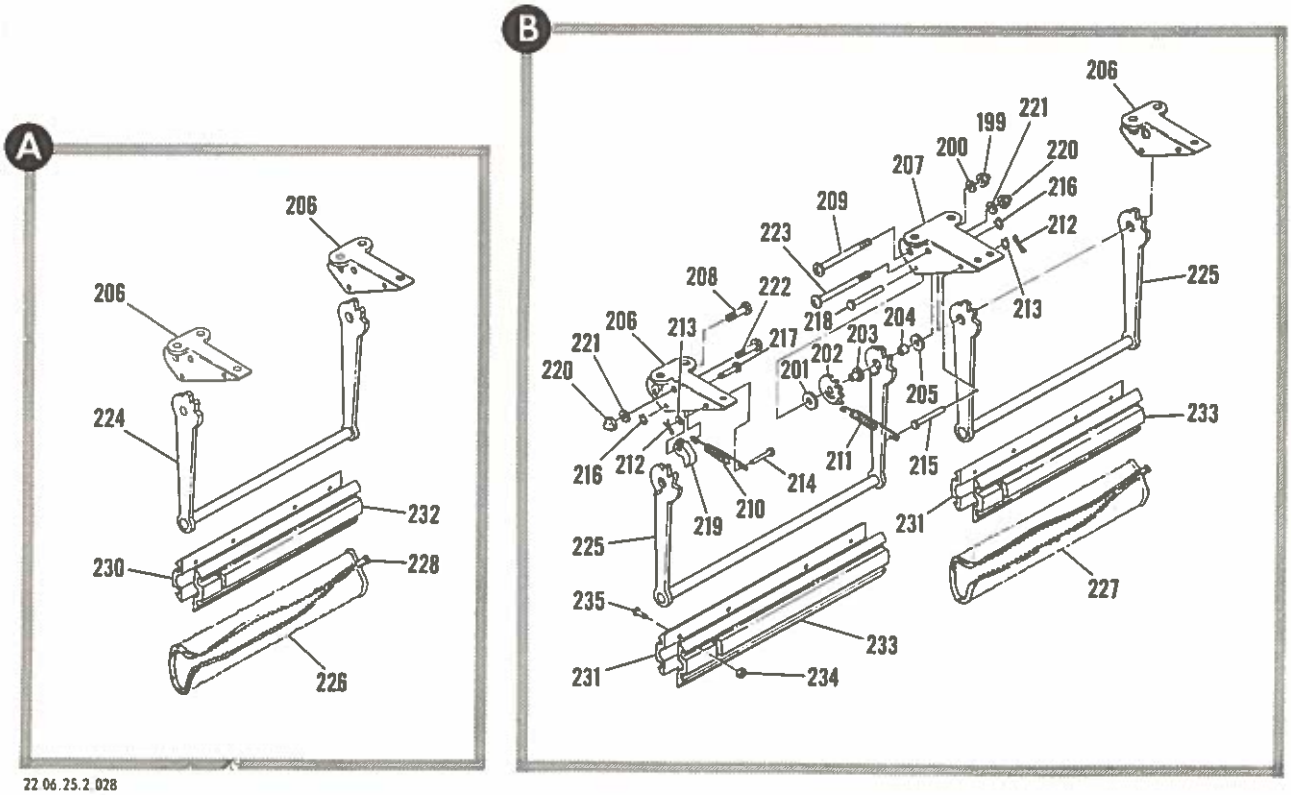

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 153	31-92330-205	. FAIRING, SEAT RECLINE BUTTON -V83115-	A-N			1
		ATTACHING PARTS				
- 154	AN526-832R6	. SCREW	A-N			3
		----x----				
- 155	AN380-2-1	. PIN, COTTER	C-N			1
	AN380-2-1	. PIN, COTTER	A-B			2
- 156	MS20392-1-9	. PIN, CLEVIS	C-N			1
	MS20392-1-13	. PIN, CLEVIS	A-B			2
- 157	AN960C4L	. WASHER	C-N			1
- 158	22-94510	. FORK, RECLINE END -V83115-	C-N			1
	22-92414-9	. FORK, RECLINE MECHANISM -V83115-	A-B			1
	22-92414-7	. LINK, RECLINE MECHANISM -V83115-	A-B			1
- 159	AN742D4	. CLAMP, SUPPORT CABLE	C-N			1
		ATTACHING PARTS				
- 160	NAS679A3	. NUT	C-N			1
- 161	AN3-3A	. BOLT	C-N			1
		----x----				
- 162	22-92422-7	. CLIP, SUPPORT CABLE RIVETED -V83115-	C-N			1
- 163	30-93555-863	. CABLE ASSEMBLY, INBD CENTER ARMREST	C-N			1
		SWAGED -V83115-				
- 164	22-92421-7	. ARM, RECLINE MECHANISM -V83115-	C-N			1
	MS16562-33	. PIN, SLOTTED	A-B			1
	22-92418-7	. ARM, RECLINE MECHANISM -V83115-	A-B			1
- 165	NAS679A3	. NUT	C-N			1
- 166	AN3-5A	. BOLT	C-N			1
- 167	22-92417-7	. ARM, RECLINE MECHANISM -V83115-	C-N			1
- 168	MS16562-33	. PIN, SLOTTED	A-N			1
- 169	22-92415-7	. ACTUATOR, RECLINE MECHANISM ARM -V83115-	A-N			1
- 170	22-92416-7	. SHAFT, RECLINE MECHANISM PIVOT -V83115-	A-N			1
- 171	295202-413	. GROMMET, SPLIT NYLON MONADNOCK MILLS	A-N			3
		SAN LEANDRO, CALIFORNIA				
- 172	30-94520-3	. FOOT ASSEMBLY, PASSENGER SEAT LH -V83115-	A-C,	E-H		1
	30-94520-4	. FOOT ASSEMBLY, PASSENGER SEAT RH -V83115-	D,J-	N		1
		ATTACHING PARTS				
- 173	NAS1291-6	. NUT	A-N			2
- 174	AN960-616L	. WASHER	A-N			2
- 175	NAS623-6-13	. SCREW	A-N			2
		----x----				
- 176	NAS561P3-15	. . PIN, ROLL	A-N			4
- 177	30-94520-7	. . TUBE, -V83115-	A-N			1
	30-94520-803	. . FITTING ASSEMBLY, AFT LH -V83115-	A-C,	E-H		1
	30-94520-804	. . FITTING ASSEMBLY, AFT RH -V83115-	D,J-	N		1
	AN381-2-6	. . . PIN, COTTER	A-N			1
- 178	MS20392-1-19	. . . PIN, CLEVIS	A-N			1
- 179	30-94529-7	. . . PLUNGER, AFT FLOOR FITTING -V83115-	A-N			1
- 180	30-94528-201	. . . DRIVER, AFT FLOOR FITTING -V83115-	A-N			1
- 181	30-94530-7	. . . SPRING, AFT FLOOR FITTING COMPRESSION	A-N			1
		-V83115-				
- 182	30-94531-9	. . . PIN, AFT FLOOR FITTING LOCK -V83115-	A-N			1
- 183	30-94527-7	. . . FITTING, AFT FLOOR LH -V83115-	A-C,	E-H		1
	30-94527-8	. . . FITTING, AFT FLOOR RH -V83115-	D,J-	N		1
	30-94520-5	. . FITTING ASSEMBLY, FWD LH -V83115-	A-C,	E-H		1
	30-94520-6	. . FITTING ASSEMBLY, FWD RH -V83115-	D,J-	N		1
	AN380-2-3	. . . PIN, COTTER	A-N			1
- 184	AN320C3	. . . NUT	A-N			1
- 185	AN960C10L	. . . WASHER	A-N			2
- 186	AN502-10-20	. . . SCREW	A-N			1
- 187	AN364-1032	. . . NUT	A-N			1
- 188	AN3C12A	. . . BOLT	A-N			1
- 189	30-94522-7	. . . BLOCK, FWD FLOOR FITTING -V83115-	A-N			1
- 190	30-94524-7	. . . WEDGE, FWD FLOOR FITTING -V83115-	A-N			1
- 191	30-94523-7	. . . PLUNGER, FWD FLOOR FITTING -V83115-	A-N			1
- 192	30-94525-7	. . . SPRING, FWD FLOOR FITTING COMPRESSION	A-N			1
		-V83115-				
- 193	30-94521-7	. . . FITTING, FWD FLOOR -V83115-	A-N			1


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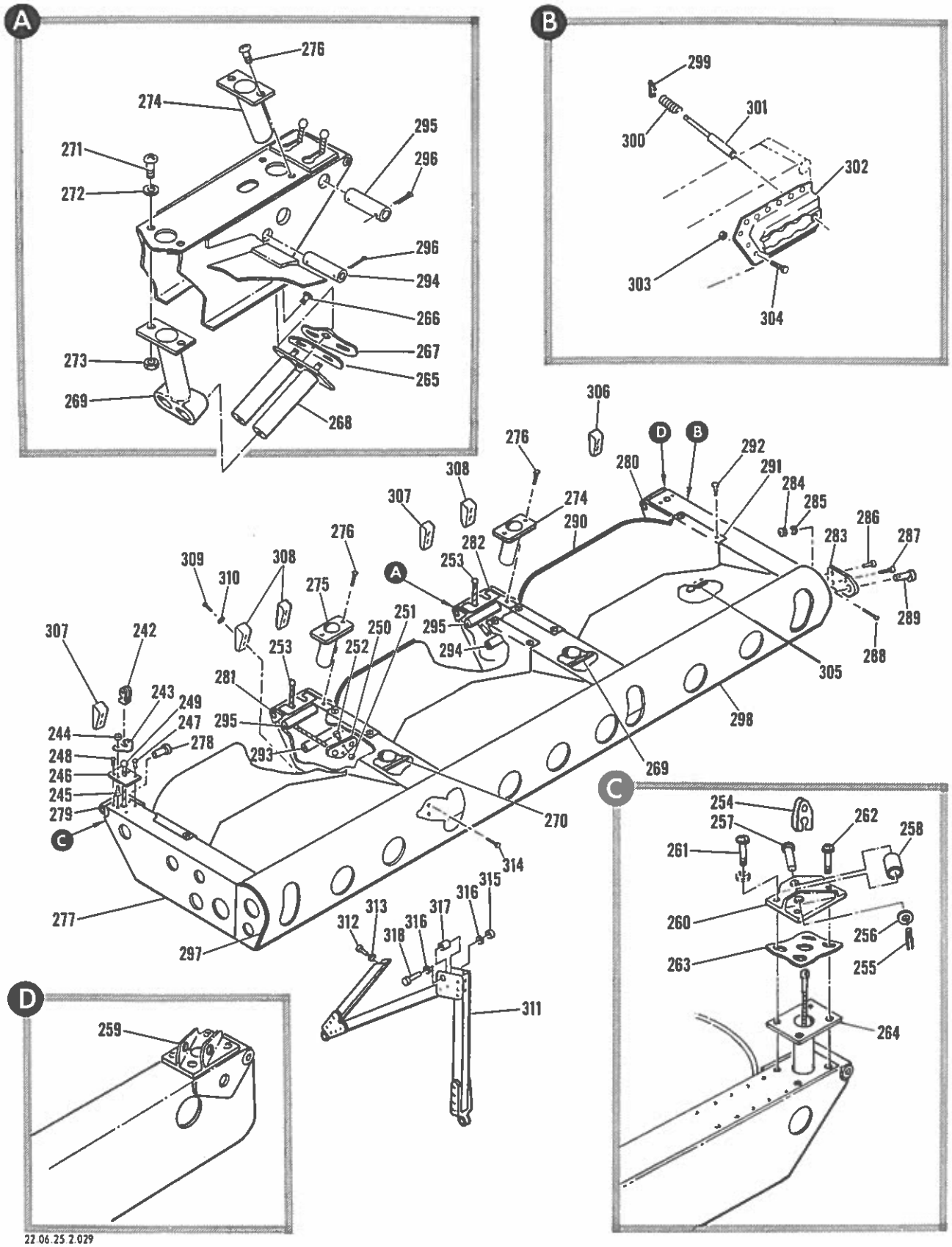
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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 194	30-93567-5	. FOOTREST ASSEMBLY, TRIPLE COACH SEAT INBD -V83115-	A-B,	J,N		1
- 195	30-93567-3	. FOOTREST ASSEMBLY, TRIPLE COACH SEAT OUTBD -V83115-	A-B,	J,N		1
		ATTACHING PARTS				
- 196	NAS1203-5	. BOLT	A-B			12
	NAS1203-5	. BOLT	J,N			8
- 197	NAS1203-3	. BOLT	A-B			4
	NAS1203-6	. BOLT	J,N			8
- 198	AN960D10L	. WASHER	A-B			4
	22-92569-17	. SHIM, BASE FRAME FOOTREST -V83115-	J,N			4
		----x----				
- 199	52NKTE048	. . NUT, SELF LOCKING CAP NYLON CONVAIR 96-37568-004 -V72962-	A-B,	J,N		3
- 200	AN960PD416L	. . WASHER	A-B,	J,N		3
- 201	AN960-616	. . WASHER	A-B,	J,N		6
- 202	30-93523-7	. . TRIPLATE, FOOTREST RATCHET -V83115-	A-B,	J,N		6
- 203	NAS77-4-20	. . BUSHING	A-B,	J,N		6
- 204	NAS75-4-010	. . BUSHING	A-B,	J,N		6
- 205	22-92420-7	. . WASHER, FOOTREST NYLON -V83115-	A-B,	J,N		6
- 206	30-93531-9	. . BRACKET, FOOTREST ATTACHMENT -V83115-	A-B,	J,N		4
- 207	30-93531-7	. . BRACKET, FOOTREST ATTACHMENT -V83115-	A-B,	J,N		1
- 208	NAS623-4-12	. . SCREW	A-B,	J,N		4
- 209	NAS623-4-24	. . SCREW	A-B,	J,N		1
- 210	30-93525-7	. . SPRING, EXTENSION -V83115-	A-B,	J,N		6
- 211	30-93534-7	. . SPRING, EXTENSION -V83115-	A-B,	J,N		6
- 212	AN380-1-2	. . PIN, COTTER	A-B,	J,N		5
- 213	AN960PD8	. . WASHER	A-B,	J,N		5
- 214	MS20392-1-25	. . PIN, CLEVIS	A-B,	J,N		4
- 215	MS20392-1-47	. . PIN, CLEVIS	A-B,	J,N		1
- 216	5103-15	. . RING, RETAINING SNAP CONVAIR 97-61512-004 -V89462-	A-B,	J,N		5
- 217	22-92419-7	. . PIN, FOOTREST STOP -V83115-	A-B,	J,N		4
- 218	22-92419-9	. . PIN, FOOTREST STOP -V83115-	A-B,	J,N		1
- 219	30-93527-7	. . PAWL, FOOTREST RATCHET -V83115-	A-B,	J,N		6
		ATTACHING PARTS				
- 220	52NKTE048	. . NUT, SELF LOCKING CAP NYLON CONVAIR 96-37568-004 -V72962-	A-B,	J,N		5
- 221	AN960PD416L	. . WASHER	A-B,	J,N		5
- 222	NAS623-4-12	. . SCREW	A-B,	J,N		4
- 223	NAS623-4-24	. . SCREW	A-B,	J,N		1
		----x----				
- 224	30-93565-801	. . CROSSBAR ASSEMBLY, INBD FOOTREST WELDED -V83115-	A-B,	J,N		1
- 225	30-93565-5	. . CROSSBAR ASSEMBLY, OUTBD FOOTREST WELDED -V83115-	A-B,	J,N		2
- 226	30-93567-17	. . CARPET, INBD FOOTREST STITCHED -V83115-	A-B,	J,N		1
- 227	30-93567-15	. . CARPET, OUTBD FOOTREST STITCHED -V83115-	A-B,	J,N		2
- 228	30-93567-27	. . ZIPPER, INBD FOOTREST STITCHED -V83115-	A-B,	J,N		2
- 230	30-93566-19	. . CLAMSHELL, INBD FOOTREST CROSSBAR UPPER -V83115-	A-B,	J,N		1
- 231	30-93566-21	. . CLAMSHELL, OUTBD FOOTREST CROSSBAR UPPER -V83115-	A-B,	J,N		2
- 232	30-93566-205	. . CLAMSHELL, INBD FOOTREST CROSSBAR LOWER -V83115-	A-B,	J,N		1
- 233	30-93566-207	. . CLAMSHELL, OUTBD FOOTREST CROSSBAR LOWER -V83115-	A-B,	J,N		2
		ATTACHING PARTS				
- 234	AN364-832NC2	. . NUT	A-B,	J,N		24
- 235	AN515-8-7	. . SCREW	A-B,	J,N		24
		----x----				
- 236	NAS679A3	. NUT	A-B,	J,N		7
- 237	NAS623-3-1	. SCREW	A-B,	J,N		4
- 238	NAS623-3-2	. SCREW	A-B,	J,N		3
- 239	22-92567-211	. CHANNEL, BASE FRAME FOOTREST -V83115-	A-B,	J,N		1
- 240	22-92567-217	. BRACKET, BASE FRAME FOOTREST -V83115-	A-B,	J,N		1

SEE PAGE 25 FOR CODE EXPLANATION

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1	22-92567-218	BRACKET, BASE FRAME FOOTREST RH -V83115-	J,N			1
- 241	22-92567-213	. CLIP, BASE FRAME FOOTREST -V83115-	A-B,	J,N		1

SEE PAGE 25 FOR CODE EXPLANATION


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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 242	22-92395	. FITTING ASSEMBLY, CABLE BELT RIVETED -V83115-	A-H,	N		6
- 243	30-93802-203	. PLATE, PASSENGER SEAT BASE NYLON -V83115- ATTACHING PARTS	A-H,	N		2
- 244	NAS679A3	. NUT	A-H,	N		4
- 245	AN509-10R8	. SCREW	A-H,	N		4
		----x----				
- 246	22-92547-205	. PLATE, ENERGY ABSORBER -V83115- ATTACHING PARTS	A-H,	N		2
- 247	NAS1403-5	. SCREW	A-H,	N		4
- 248	NAS1403-6	. SCREW	A-H,	N		4
		----x----				
- 249	22-92374-851	. CABLE ASSEMBLY, SEAT BELT INBD AND OUTBD SWAGED -V83115-	A-H,	N		2
- 250	22-92547-203	. PLATE, ENERGY ABSORBER -V83115- ATTACHING PARTS	A-H,	N		2
- 251	NAS679A3	. NUT	A-H,	N		4
- 252	AN526-1032R7	. SCREW	A-H,	N		4
		----x----				
- 253	22-92374-853	. CABLE ASSEMBLY, SEAT BELT CENTER SWAGED -V83115-	A-H,	N		4
- 254	30-93571-7	. YOKE, SEAT BELT BOLT ATTACH -V83115-	J-M			6
- 255	AN380-3-2	. PIN, COTTER	J-M			2
- 256	AN960D516	. WASHER	J-M			2
- 257	MS20392-4-35	. PIN, CLEVIS	J-M			2
- 258	22-92392-7	. ROLLER, ENERGY ABSORBER -V83115-	J-M			2
- 259	30-93570-7	. SUPPORT, ENERGY ABSORBER ROLLER OUTBD LH -V83115-	J-M			1
- 260	30-93570-8	. SUPPORT, ENERGY ABSORBER ROLLER INBD RH -V83115- ATTACHING PARTS	J-M			1
- 261	NAS1403-5	. SCREW	J-M			4
- 262	NAS1403-6	. SCREW	J-M			4
		----x----				
- 263	22-92389-201	. SEAL, ENERGY ABSORBER DUST -V83115-	J-M			2
- 264	22-92543-851	. ABSORBER ASSEMBLY, INBD AND OUTBD WELDED -V83115-	J-M			2
- 265	22-92547-203	. PLATE, ENERGY ABSORBER -V83115- ATTACHING PARTS	J-M			2
- 266	AN526-1032R10	. SCREW	J-M			4
- 267	22-92389-203	. SEAL, ENERGY ABSORBER DUST -V83115-	J-M			2
		----x----				
- 268	22-92542-851	. ABSORBER ASSEMBLY, CENTER WELDED -V83115-	J-M			2
- 269	31-92510-201	. SOCKET ASSEMBLY, NYLON FRONT -V83115-	A-N			1
- 270	31-92510-202	. SOCKET ASSEMBLY, NYLON FRONT -V83115- ATTACHING PARTS	A-N			1
- 271	AN526-1032R6	. SCREW	A-N			8
- 272	AN960D10L	. WASHER	A-H,	N		8
- 273	NAS679A3	. NUT	A-H,	N		8
		----x----				
- 274	31-92510-205	. SOCKET ASSEMBLY, NYLON REAR -V83115-	A-N			1
- 275	31-92510-206	. SOCKET ASSEMBLY, NYLON REAR -V83115- ATTACHING PARTS	A-N			1
- 276	AN526-1032R7	. SCREW	A-N			4
		----x----				
- 277	31-92510-3	. BASE ASSEMBLY, TRIPLE COACH PASSENGER SEAT LH -V83115-	C			1
	31-92510-803	. BASE ASSEMBLY, TRIPLE COACH PASSENGER SEAT LH -V83115-	A-B			1
	31-92510-853	. BASE ASSEMBLY, TRIPLE COACH PASSENGER SEAT LH -V83115-	E-H			1
	31-92510-5	. BASE ASSEMBLY, TRIPLE COACH PASSENGER SEAT RH -V83115-	D			1
	31-92510-854	. BASE ASSEMBLY, TRIPLE COACH PASSENGER SEAT RH -V83115-	J-N			1
- 278	NAS77-5-100	. . BUSHING	A-N			6
		SEE PAGE 25 FOR CODE EXPLANATION				

FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE CUST	FROM	TO	UNITS PER ASSY
1 - 279	22-92519-205	. . PIVOT, SEAT BACK ATTACHMENT INBD -V83115-	A-N			1
- 280	22-92520-9	. . PIVOT, SEAT BACK ATTACHMENT OUTBD -V83115-	A-N			1
- 281	22-92519-203	. . PIVOT, SEAT BACK ATTACHMENT CENTER -V83115-	A-N			2
- 282	30-93802-7	. . STRIP, SEAT BASE NYLON RIVETED -V83115-	A-N			2
- 283	30-93560-7	. . RAIL, SIDE FITTING FWD LH -V83115-	A-C,	E-H		1
	30-93560-8	. . RAIL, SIDE FITTING FWD RH -V83115-	D,J-	N		1
		ATTACHING PARTS				
- 284	NAS1291-3	. . NUT	A-N			4
- 285	AN960-10L	. . WASHER	A-N			4
- 286	NAS1203-5	. . BOLT	A-N			2
- 287	NAS1203-7	. . BOLT	A-N			2
		----x----				
	AN380-1-1	. . PIN, COTTER	A-N			1
- 288	AN392-60	. . PIN, FLAT HEAD	A-N			1
- 289	30-93558-7	. . CAM, PASSENGER SEAT ANTI-RATTLE -V83115-	A-N			1
- 290	22-92353-13	. . BEAD, SEAT PAN RUBBER -V83115-	A-N			3
- 291	22-92516-7	. . PAN, PASSENGER SEAT -V83115-	A-N			3
		ATTACHING PARTS				
- 292	AN526-1032-5	. . SCREW	A-N			12
		----x----				
- 293	22-92546-13	. . TUBE, ENERGY ABSORBER -V83115-	A-N			1
- 294	22-92546-11	. . TUBE, ENERGY ABSORBER -V83115-	A-N			1
- 295	22-92546-7	. . TUBE, ENERGY ABSORBER -V83115-	A-N			2
- 296	AN380-2-4	. . PIN, COTTER	A-N			8
- 297	22-92531-17	. . FAIRING, FRAME FRONT RIVETED -V83115-	A-N			1
- 298	22-92353-7	. . HEAD, FAIRING RUBBER -V83115-	A-N			1
	30-93562-1	. . PIN ASSEMBLY, PASSENGER SEAT AFT SIDE -V83115-	A-N			1
- 299	30-93561-7	. . . RING, SPLIT -V83115-	A-N			1
- 300	30-93563-7	. . . SPRING, COMPRESSION -V83115-	A-N			1
- 301	30-93564-7	. . . PIN, PASSENGER SEAT AFT SIDE -V83115-	A-N			1
- 302	30-93533-7	. . RAIL, SIDE FITTING AFT LH RIVETED -V83115-	A-C,	E-H		1
	30-93533-8	. . RAIL, SIDE FITTING AFT RH RIVETED -V83115-	D,J-	N		1
- 303	NAS1291-3	. . NUT	A-N			3
- 304	NAS1103-3	. . BOLT	A-N			3
- 305	22-92360-7	. . CLIP, ELASTIC CORD RIVETED -V83115-	A-N			6
- 306	22-92518-202	. . STOP, FOOD TRAY -V83115-	A-N			1
- 307	22-92518-201	. . STOP, FOOD TRAY -V83115-	A-N			2
- 308	22-92518-7	. . STOP, FOOD TRAY -V83115-	A-N			3
		ATTACHING PARTS				
- 309	NAS1103-2	. . BOLT	A-N			12
- 310	AN960D10L	. . WASHER	A-N			12
		----x----				
- 311	31-92518-1	. . LEG ASSEMBLY, PASSENGER SEAT LH RIVETED -V83115-	A-C,	E-H		1
	31-92518-2	. . LEG ASSEMBLY, PASSENGER SEAT RH RIVETED -V83115-	D,J-	N		1
		ATTACHING PARTS				
- 312	NAS1104-3	. . BOLT	A-N			3
- 313	AN960D10L	. . WASHER	A-N			3
- 314	MS20004-4	. . BOLT	A-N			2
- 315	NAS679A4	. . NUT	A-N			1
- 316	AN960D416	. . WASHER	A-N			2
- 317	NAS43DD4-48	. . SPACER	A-N			1
- 318	NAS1404-17	. . BOLT	A-N			1
		----x----				

SEE PAGE 25 FOR CODE EXPLANATION

EXPLANATION OF IPC USAGE CODE

CODE	ASSEMBLY P/N	TITLE	CUSTOMER MODEL NO.	CUSTOMER
A =	31-92504-3	LH Triple Coach	22(M)-4-1	CAT
B =	31-92504-813	LH Triple Coach	22(M)-4-1	CAT
C =	31-92504-805	LH Triple Coach	22(M)-22-1 thru -5	JAL
D =	31-92504-2	RH Triple Coach	30-6 -3 thru -9	SWISSAIR
D =	31-92504-2	RH Triple Coach	30-6-1 thru -2	
E =	30-94550-853	LH Triple Coach	22(M)-3 -5	CATHAY
E =	30-94550-853	LH Triple Coach	22(M)-3 -1,-2,-3,-4,-6,-7	
F =	30-94550-855	LH Triple Coach	22(M)-3 -5	CATHAY
F =	30-94550-855	LH Triple Coach	22(M)-3 -1,-2,-3,-4,-6,-7	
G =	30-94550-851	LH Triple Coach		
H =	30-94550-857	LH Triple Coach		
J =	30-94550-860	RH Triple Coach		
K =	30-94550-862	RH Triple Coach		
L =	30-94550-864	RH Triple Coach	30-5 -5 thru -24	AAL
L =	30-94550-864	RH Triple Coach	30-5-1,-2,-3,-4,-25	
M =	30-94550-866	RH Triple Coach	30-5-5 thru -24	AAL
M =	30-94550-866	RH Triple Coach	30-5-1,-2,-3,-4,-25	
N =	30-94550-868	RH Triple Coach	30-8-1 thru -3	VARIG

PASSENGER SEAT ASSEMBLIES - TRIPLE
(Convair Part No.s 30-94550 and 31-92504 Series)

ATA NO. 25-2-33

CONVAIR JET AIRLINER OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 22(M)-3, 22(M)-4, 22(M)-22, 30-5, 30-6, and 30-8

May 31/62

List of Effective Pages

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25-2-33	301	May 31/62	D
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25-2-33	509	May 31/62	D
	BLANK		
25-2-33	701	May 31/62	D
	BLANK		
25-2-33	801	May 31/62	D
25-2-33	802	May 31/62	D
25-2-33	901	May 31/62	D
	BLANK		
25-2-33	1001	May 31/62	D
	BLANK		
25-2-33	IPC 1	May 31/62	D
	BLANK		
25-2-33	IPC 3	May 31/62	D
25-2-33	IPC 4	May 31/62	D
25-2-33	IPC 5	May 31/62	D
25-2-33	IPC 6	May 31/62	D
25-2-33	IPC 7	May 31/62	D
25-2-33	IPC 8	May 31/62	D
25-2-33	IPC 9	May 31/62	D
25-2-33	IPC 10	May 31/62	D
25-2-33	IPC 11	May 31/62	D
25-2-33	IPC 12	May 31/62	D
25-2-33	IPC 13	May 31/62	D
25-2-33	IPC 14	May 31/62	D
	BLANK		
25-2-33	IPC 16	May 31/62	D
25-2-33	IPC 17	May 31/62	D
25-2-33	IPC 18	May 31/62	D
25-2-33	IPC 19	May 31/62	D
25-2-33	IPC 20	May 31/62	D
	BLANK		
25-2-33	IPC 22	May 31/62	D
25-2-33	IPC 23	May 31/62	D
25-2-33	IPC 24	May 31/62	D
25-2-33	IPC 25	May 31/62	D
	BLANK		

Chapter 25

PASSENGER SEAT ASSEMBLIES

(Convair Part No. 30-94550 Series)
(Convair Part No. 31-92504 Series)

1. Description and Operation

A. Physical Description

(1) The Convair 30-94550 series and 31-92504 series triple coach passenger seats are primarily riveted sheetmetal structures and consist of the major components of seat base assembly, back assemblies, leg assembly, side panel and armrest assemblies and food tray assemblies. The seats are mounted as units on two lock fittings at the outboard end at seat cushion level and two floor attach fittings at the base of the single leg.

(2) Each seat provides foam-padded seat bottom and back cushions, foam-padded armrests, a pull-out food tray installation in the rear of the seat back, a lever, cable and lock installation for controlling recline and locking of the seat back, safety for controlling recline and locking of the seat back, safety belt attach fittings and ash trays with sliding closures.

(3) Some seats not having passenger accommodations immediately aft contain dummy food trays in the rear of the seat back.

(4) Some seats, applicable on usage code A, B, J and N, provide variable positioning, passenger footrest assemblies mounted on the aft underside of the seat base frame.

(5) Each functional food tray is provided with a recess at the rear of the seat back. Support arms, pivoted on the seat back pivot pin, carry a plastic tray pivoted on the upper end of the support arms. When not in use the tray is folded into the seat back and latched to a keeper in the seat structure. When the latch is pulled out the tray folds down and the support arms pivot rearward to make the tray level. Stops on the tray pivot point control the tray angle. Stops on the seat base structure control the limit of the support arm motion.

B. Leading Particulars

Size (tray closed)

Width	65 inches
Height	43 inches
Length	28 inches
Weight (approx.)	78 pounds
Angle of Recline	38 degrees
Recovery Time	2.0 seconds
Breakover	35 pounds steady pull

C. Operation

(1) The key operating feature of the seat is the reclining back and control. A lever in each side armrest of each seat is connected by a cable to a seat lock unit installed in the seat base structure.

(2) A breakover mechanism is mounted on the aft end of the seat lock unit and the longer leg of the seat back engages a slot in the lower end of the breakover mechanism below the seat back pivot point. By this arrangement the seat lock controls movement of the seat back aft of normal. The breakover mechanism limits foward motion of the seat back to a normal forward seating position until a load of over 35 pounds is applied forward.

(3) The seat lock is a self-contained unit mounted under the base assembly. When the lever is lifted the cable is pulled and the arm at the lock unit is actuated. The seat lock will release for back recline up to a maximum of 38 degrees. When reclined, the built-in spring provides recovery force for returning to normal position upon re-tripping the lever.

2. Disassembly

A. General

(1) The upholstery covers are fastened by Velcro tapes. The fixed section is a tape with small loops or eyes covering the surface; the section sewn to the cover is a tape of short stiff-hooked fibers. When the cover section is pressed flat against the fixed section, the short fibers enter the eyes to form many hook-and-eye matings. This fastener is highly resistant to a pull in the plane of the joint, but separates readily when pulled vertically to the plane.

(2) The seat cushion foam lies loose in the pan and is effectively held by the cushion cover. All other foam is cemented in place and is likely to be damaged beyond use by removal. Handle cemented foam pieces with care to avoid pulling or stressing foam. Refer to paragraphs 5.B for procedure to remove or install foam.

B. Seat Cushions (See IPC Figure 1.)

(1) Remove seat cushion assembly by peeling Velcro from center of cover, on front underside of seat base, across front and around cover.

(2) Remove cover (48) from cushion (49).

(3) Remove pad (50) from base assembly fairing.

C. Seat Back and Food Tray Assemblies (See IPC Figure 1, Sheet 1.)

(1) Remove each seat back and food tray assembly or dummy fairing (47) from base assembly by removing two pins (5).

(2) Remove latch (31) from tray assembly by removing three screws (30). Applicable on usage code A-G, J, L, N.

(3) Remove table assembly from support assembly by removing four screws (32). Applicable on usage code A-G, J, L, N.

(4) Remove four screws (43), four bushings (44), two bushings (45 from support (46). Applicable on usage code A-G, J, L, N.

D. Inboard and Outboard Footrest Assemblies (See IPC Figure 1, Sheet 4.) Applicable on Usage Code A, B, J, N.

(1) Applicable on usage code A, B only. From the aft underside of the seat base frame remove inboard footrest assembly (194) and outboard footrest assembly (195) by removing twelve bolts (196), four bolts (197) and four washers (198).

(2) Applicable on usage code J, N only. From the aft underside of the seat base frame remove inboard footrest assembly (194) and outboard footrest assembly (195) by removing eight bolts (196), eight bolts (197) and four shims (198).

(3) Disassemble inboard footrest assembly (194) by removing nut (199), washer (200), screw (208), nut (220), washer (221), screw (222), retaining ring (216), pin (217), cotter pin (212), washer (213), and clevis pin (214) from most outboard bracket (206). Remove screw (208), nut (220), washer (221), screw (222), retaining ring (216), pin (217), cotter pin (212), washer (213) and clevis pin (214) from inboard bracket (206). Remove washer (201), triplate (202), bushing (203), bushing (204), washer (205), spring (211), spring (210) and pawl (219) from each bracket (206).

(a) Remove crossbar assembly (224) with lower footrest attached from both brackets (206).

(b) Disassemble lower footrest parts by removing carpet (226). Remove upper and lower clamshells (230) and (232) from crossbar assembly (224) by removing four nuts (234) and four screws (235).

(4) Disassemble outboard footrest assembly (195) by removing two brackets (206), following disassembly procedure outlined in paragraph 2.D.(3). Remove nut (199), washer (200), screw (209), nut (220), washer (221), screw (223), retaining ring (216), pin (218), cotter pin (212), washer (213) and clevis pin (215) from center bracket (207). Remove two washers (201), two triplates (202), two bushings (203), two bushings (204), two washers (205), two springs (210), two springs (211) and two pawls (219) from center bracket (207).

(a) Remove two crossbar assemblies (225) with lower footrests attached from one bracket (207) and two brackets (206).

(b) Disassemble lower footrest parts by removing carpet (227) on each crossbar assembly (225). Remove upper and lower clamshells (231) and (233) from each crossbar assembly (225) by removing four nuts (234) and four screws (235).

E. Fairings (See IPC Figure 1, Sheet 1)

(1) From the aft side of the base assembly (277) remove fairings (57) and (56) by removing eight screws (58).

(2) Remove center recline button fairing (153) from seat base assembly (277) by removing three screws (154).

(3) From the inboard leg of the inboard seat back remove fairing (59) by removing four screws (62).

(4) From the inboard leg of the center seat back remove fairing (61) by removing four screws (62).

(5) From the outboard leg of the outboard seat back remove fairing (60) by removing four screws (62).

F. Back Assembly (See IPC Figure 1, Sheet 1)

(1) Slip back cover (1) from seat back assembly. From aft side of seat back assembly and while removing cover (1), disconnect literature pocket bungee cords from seat back structure assembly (6).

(2) Remove cord (4) from cover assembly (1).

(3) Remove cushion assembly (3) and pillow assembly (2) from seat back structure (6).

(4) From the longer leg of the seat back structure assembly (6) remove nut (8), washer (9), bolt (10), washer (11) and spacer (12).

(5) Remove bushing (13), bushing (14), washer (15), angle (16), channel (17) and clip (18).

(6) From the shorter leg of the seat back structure assembly (6) remove bushing (19), washer (20), shim (21), bushing (22), angle (23) and channel (24).

(7) From the upper aft side of the seat back structure assembly (6) remove latch (25) by removing two screws (26) and two shims (27).

(8) Remove latch bracket (28).

G. Inboard and Outboard Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Remove ash tray assembly (86) from armrest cover assembly (87) by lifting up and forward past fully opened ash tray cover assembly (108).

Applicable on usage code C only. Remove ash tray assembly from armrest cover assembly by lifting straight up at ash tray escutcheon.

(2) Remove each armrest cover assembly (87) by removing two screws (88).

(3) Slide each armrest cover assembly forward until it stops, or approximately one inch. Lift aft end of armrest cover assembly with fingers to clear slots in armrest structure assembly (123). Remove cover assembly.

(4) Remove ash tray escutcheon (89) from armrest cover assembly (87) by removing one screw (90).

(5) Remove ash tray cover assembly (108) from armrest structure assembly (123) by removing two screws (110) and knob (109). Slide ash tray cover plate (111) aft until it clears guides in armrest structure assembly.

(6) Slip leather or fabric armrest cover (91) from armcap structure assembly (97) and remove armrest top pad (92), two outer armrest side pads (93) and two inner armrest side pads (94).

(7) Remove two armcap pins (96) and two washers (95) from aft underside of armcap structure assembly (97).

H. Inboard and Outboard Scuff Cup (See IPC Figure 1, Sheet 2)

(1) Remove scuff cap (112) by removing screws (113) from armrest structure assembly (123).

I. Inboard and Outboard Armrest Fairings (See IPC Figure 1, Sheet 1)

(1) Remove inboard armrest fairing (63) from armrest structure assembly (123) by removing three screws (64).

(2) Remove outboard arm fairings (65) and (66) from outboard armrest structure assembly (124) by removing five screws (67).

J. Inboard Center Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Remove cover assembly (128) from armrest assembly (136) by removing two screws (129). Slide cover assembly forward until it stops. Lift aft end of cover assembly with fingers to clear slots in armrest assembly (136).

(2) Slip cover (130) from armcap structure assembly (135).

(3) Remove top pad (131) and side pad (132) from armcap structure assembly (135).

(4) Remove two pins (134) and two washers (133) from armcap structure assembly (135).

K. Outboard Center Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Remove cover assembly (98) from armrest assembly (127) by removing two screws (99). Slide cover assembly forward until it stops. Lift aft end of cover assembly with fingers to clear slots in armrest assembly (127).

(2) Remove ash tray escutcheon assembly (100) from cover assembly (98) by removing screw (101).

(3) Remove ash tray assembly (86) from cover assembly (98) by lifting straight up past fully opened ash tray cover assembly (108).

(4) Slip armrest cover (102) from armcap structure assembly (107).

(5) Remove ash tray cover assembly (108) from armcap structure assembly (107) by sliding forward past guides.

(6) Disassembly ash tray cover assembly (108) by removing two screws (110). Remove knob (109) from plate (111).

(7) Remove armcap top pad (103) and armrest side pad (104) from armcap structure assembly (107).

(8) Remove two pins (106) and two washers (105) from armcap structure assembly (107).

L. Inboard and Outboard Recline Cable and Lever Assemblies (See IPC Figure 1, Sheet 2).

(1) From ash tray well of armrest structure assemblies (123) and (124) disconnect terminal end of cable assembly (122) from lever assembly (121).

(2) From each cable assembly (122) remove three clamps (114) by removing three nuts (115), three washers (116) and three screws (117) from within armrest structure assemblies (123) and (124) and aft side of bulkhead in base assembly. Remove cable assembly.

(3) Remove retaining ring (119) from recline lever pin (118) in armrest structure assemblies (123) and (124) and remove pin (118), spring (120) and lever assembly (121).

M. Inboard and Outboard Armrest Structure Assemblies (See IPC Figure 1, Sheet 2)

(1) Remove each armrest structure assembly (123) and (124) from base assembly by removing three bolts (125) and three washers (126).

N. Center Recline Control (See IPC Figure 1, Sheet 3).

(1) Applicable on usage code C-N.

(a) From the underside of seat base assembly beneath the inboard center armrest, disconnect cable assembly (163) from recline mechanism arm (164).

(b) Remove cotter pin (155), clevis pin (156), washer (157) and fork (158) from aft end of cable assembly (163).

(c) Remove cable support clamp (159) from clip (162) on seat base assembly by removing nut (160) and bolt (161). Remove cable assembly (163).

(d) Disengage spring (81) from recline mechanism arm (164).

(e) Remove nut (165) and bolt (166) from recline mechanism arm (164). Remove arm (164) from shaft (170).

(f) Remove slotted pin (168) and slide shaft (170) to free actuator (169). Remove shaft (170) and three grommets (171).

(2) Applicable on usage code A-B.

(a) From the underside of seat base assembly beneath the inboard center armrest, remove one cotter pin and one clevis pin from recline mechanism link and one cotter pin and one clevis pin from recline mechanism fork.

(b) Remove link and fork from recline mechanism arm.

(c) Remove slotted pin and slide shaft (170) to free recline mechanism arm.

(d) Remove slotted pin (168) from other end of shaft (170) to free actuator (169). Remove shaft (170) and three grommets (171).

O. Stewardess Step (See IPC Figure 1, Sheet 1)

(1) Remove step (54) from base assembly by removing two screws (55).

P. Foot Assembly (See IPC Figure 1, Sheet 3)

(1) Remove fairing (52) from seat leg assembly by removing four screws (53).

(2) Remove foot assembly (172) from seat leg assembly by removing two nuts (173), two washers (174) and two screws (175).

(3) Remove four pins (176) from fittings (183) and (193). Remove tube (177), cotter pin, clevis pin (178), plunger (179), driver (180) spring (181) and pin (182) from fitting (183).

(4) Remove tube (177), nut (184), two washers (185), screw (186), nut (187), bolt (188), block (189), wedge (190), plunger (191) and spring (192) from forward fitting (193).

Q. Breakover Assembly (See IPC Figure 1, Sheet 2)

(1) From the aft underside of base assembly remove breakover assembly (68) from seat lock (84) and (85) by removing nut (69), washer (70) and bolt (71).

(2) Disassemble breakover assembly (68) by removing bolt (72), washer (73), spring (74), stop (75), spacer (76), yoke (77) and pin (79) from block assembly (80).

R. Seat Lock (See IPC Figure 1, Sheet 2)

(1) Remove spring (81), disconnect cable assembly and loosen nut at forward end of lock assembly. Remove seat locks (84) and (85) by lowering between seat base assembly mountings.

S. Inboard and Outboard Center Armrest Structures (See IPC Figure 1, Sheet 2)

(1) Remove outboard center armrest assembly (127) and inboard center armrest assembly (136) from the base assembly by pulling up and forward.

(a) Disconnect terminal end (upper) of cable assembly (145) from recline lever (140).

(b) Remove ring (139) from pin (138). Remove pin (138) and lever (140).

(c) Remove clamp (141) by removing screw (142) and spacer (143) from armrest assembly (136).

(d) Disconnect lower end of cable assembly (145) from bell-crank (151).

(e) Remove spring (146), ring (148), pin (147), cotter pin, pin (149), rod (150) and bellcrank (151).

(f) Remove cable assembly (145) and grommet (144) from armrest assembly (136).

T. Seat Belt Fittings (See IPC Figure 1, Sheet 5)

(1) Applicable on usage code A-H, N.

(a) Disconnect and remove six fittings (242) from two cable assemblies (249) and four cable assemblies (253).

(b) Remove two plates (243) by removing four nuts (244) and four screws (245).

(c) Remove two plates (247) by removing four screws (247) and four screws (248).

(d) Remove two plates (250) from under seat base assembly beneath center armrests by removing four nuts (251) and four screws (252).

(e) Remove four seat belt cable assemblies (253).

(2) Applicable on usage code J-M.

(a) Disconnect and remove six seat belt attach yokes (254) from two absorber assemblies (264) and two center absorber assemblies (268).

(b) Remove inboard energy absorber support (260) from seat base assembly by removing two screws (261) and two screws (262).

(c) Remove outboard energy absorber support (259) from seat base assembly by removing two screws (261) and two screws (262).

(d) Remove one dust seal (263) from under each support (259) and (260).

(e) On each support (259) and (260), remove cotter pin (255), washer (256), roller (258) and clevis pin (257).

(f) Remove inboard and outboard absorber assemblies (264) by lifting up through base assembly.

(g) Remove each center absorber assembly (268) from base assembly by removing two screws (266).

NOTE: Socket assemblies (269) and (270) must be removed concurrently. See paragraph 2.U.(7).

(h) Remove energy absorber plate (265) and dust seal (267) from each center absorber assembly (268).

U. Base Assembly (See IPC Figure 1, Sheet 5)

(1) Remove bead (290) from seat pan (291).

(2) Remove six bushings (278) from pivots (279), (280) and (281).

(3) Remove pivots (279), (280) and (281).

(4) Remove rail (283) by removing four nuts (284), four washers (285), two bolts (286) and two bolts (287). Remove cam (289) and pin (288).

(5) Remove three pans (291) by removing twelve screws (292).

(6) Remove rear sockets (274) and (275) by removing four screws (276).

(7) Remove forward sockets (269) and (270) by removing eight nuts (273), eight washers (272) and eight screws (271).

NOTE: Applicable on usage code J-M only, remove sockets (269) and (270) by removing eight screws (271).

(8) Remove four energy absorber tubes (293), (294) and (295) by removing eight cotter pins (296).

(9) Remove bead (298) from fairing (297).

(10) Remove pin assembly. Remove ring (299) and spring (300) from pin (301).

(11) Remove three nuts (303) and three bolts (304) from rail (302).

(12) Remove rail (302).

(13) Remove clips (305).

(14) Remove food tray stops (306), (307) and (308) by removing twelve bolts (309) and twelve washers (310).

(15) Remove leg assembly (311) by removing three bolts (312), three washers (313), two bolts (314), one nut (315), two washers (316), one spacer (317) and one bolt (318).

3. Cleaning

A. General

(1) Clean upholstery covers installed over foam with soap and water as cleaning solvents are injurious to foam rubber.

(2) Use any standard commercial dry-cleaning procedure on a cover which has been removed.

CAUTION: REMOVE ALL RUBBER CORDS BEFORE APPLYING DRY CLEANING SOLVENT TO COVER TO PREVENT DETERIORATION.

(3) Clean hard thermoplastic fairings with cleaning agent specified in paragraph 3.D.(10), or equivalent.

(4) Clean leather trim surfaces with soap and water or with cleaning agent specified in paragraph 3.D.(10).

(5) Clean carpet trim surfaces with cleaning agent specified in paragraphs 3.D.(1), (2), (3), and (4).

WARNING: USE CLEANING SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND AVOID CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(6) Clean metal parts contaminated with oil or grease with cleaning solvent specified in paragraph 3.D.(9), or equivalent.

WARNING: USE CLEANING SOLVENT IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND AVOID CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(7) Use soap and water to clean foam rubber.

(8) Clean metal adjacent to cemented Velcro tape with a water-moistened cloth.

B. Types of Cleaning Agents

(1) No single type of cleaning agent is completely effective in the removal of all soiling; each product has its limitations. The instructions given on the product containers should be carefully followed to insure best results.

(2) Concentrated detergent preparations, commonly called upholstery shampoo, are effective in removing dry or water-borne soil. Recommended detergent preparations are specified in paragraphs 3.D.(1), (2), (3), and (4).

(3) Solvent type cleaning agents are effective in removal of oil-type soil or grease spots. Recommended solvent type cleaning agents are specified in paragraph 3.D.(5), (6), and (7). Solvent impregnated powder, specified in paragraph 3.D.(8), may be used instead of solvent cleaning agents.

C. Cleaning Procedure

(1) Vacuum upholstery thoroughly, or brush with a medium stiff bristle upholstery or clothing brush. Do not pound or beat.

(2) Test material to be cleaned by first applying cleaning agent to a small inconspicuous area of material.

(3) Use solvent type cleaning agent or solvent impregnated powder to remove oil-type soil or grease stains. Use cleaning materials sparingly, without saturating fabric, to avoid damage to foam. Apply cleaning agent with a clean soft cloth, and avoid spreading any stains by working from the outer edges toward the center.

WARNING: WORK IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS. KEEP AWAY FROM OPEN FLAMES.

NOTE: Solvents should be evaporated rapidly from the fabric surface by directing an air stream from a vacuum cleaner or by fanning toward the material to avoid formation of rings.

(4) Mix upholstery shampoo as directed on container and apply to a small area (approximately one square foot) with a small brush. Liberal application will aid in loosening soil.

(5) Roll a clean turkish towel, or other absorbent cloth, into a cylindrical shape and wipe off detergent and soil. Rotate rolled towel frequently to present a clean section to upholstery fabric surface.

NOTE: Soil is absorbed or transferred to clean towel by this procedure. Vigorous rubbing may be required to obtain even soil removal and to avoid a blotching appearance after drying.

(6) Repeat procedures in steps 3.C.(4) and 3.C.(5) over entire surface of upholstery.

D. Materials

Use materials recommended or equivalents.

	MATERIAL	IDENTIFICATION	SOURCE
(1)	Upholstery cleaner	Foam Cleaner	E.I. Du Pont de Nemours & Co. (Inc.) Wilmington, Delaware
(2)	Upholstery cleaner	Glamorene	Glamorene Inc. 270 Park Ave. New York, New York
(3)	Upholstery cleaner	Mystic Foam	Mystic Foam Corp. Cleveland, Ohio
(4)	Upholstery cleaner	Duo-Dellay	Duo-Dellay Products Co. 4201 Puleshi Highway Baltimore, Maryland
(5)	Upholstery cleaner	Du Pont Dry Clean	E.I. Du Pont de Nemours & Co. (Inc.) Wilmington, Delaware
(6)	Upholstery cleaner	Carbone Instant Foam Lather	Carbone Corporation 30-50 Greenpoint Ave. Long Island City 1, New York
(7)	Upholstery cleaner	Carbone Cleaning Fluid	Carbone Corporation 30-50 Greenpoint Ave. Long Island City 1, New York
(8)	Upholstery cleaner	Powder-ene	Von Schroder Manufacturing Company Racine, Wisconsin
(9)	Cleaning	Federal Specification P-S-661	Optional
(10)	Cleaning solvent	Sta-lube	Sta-lube 19510 S. Alameda St. Compton, California
(11)	Cement	EC-1300	Minnesota Mining and Mfg. Corporation St. Paul, Minnesota
(12)	Cement	T-161	American Latex Products Corporation Hawthorne, California
(13)	Abrasive cloth	No. 600 to 800 grade. Fed. Spec. P-C-451	Optional

MATERIAL		IDENTIFICATION	SOURCE
(14)	Crocus cloth	Fed. Spec. P-C-458	Optional
(15)	Fiber strips	One-inch wide Velcro	Vel-Cro Sales Corp. 681 Fifth Avenue New York 22, New York
(16)	Wrapping paper	Fed. Spec. UU-P-271	Optional
(17)	Tape	Fed. Spec. JAN-P-127	Optional
(18)	Abrasive cloth	No. 400 grade Fed. Spec. P-C-451	Optional
(19)	Paint	Vinyl Phenolic Moonstone Gray #169-A-56	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(20)	Paint	Semi-gloss Lacquer Tawny Beige #38-T-686	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(21)	Paint	Semi-gloss Lacquer Alpine Gray #38-H-692	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(22)	Paint	Textured "Uni-chrome" Tawny Beige #6400-292	Metal and Thermite Corp. 100 Park Avenue New York 17, New York
(23)	Paint	Semi-gloss Lacquer Pearl White #38-W-536	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(24)	Paint	Vinyl Phenolic Pearl White #169-W-515	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(25)	Paint	Semi-gloss Lacquer Baltic Blue #38-R-718	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California

MATERIAL	IDENTIFICATION	SOURCE
(26) Paint	Semi-gloss Lacquer Pearl Gray #38-H-21	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(27) Paint	Textured "Uni-chrome" Pearl Gray #6400-249	Metal and Thermite Corp. 100 Park Avenue New York 17, New York
(28) Paint	Clear Lacquer #8780	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(29) Paint	Gold Pigmented Clear Lacquer #CC 1401 Gold #8780	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(30) Paint	Vinyl Phenolic Milano Green #169-G-595	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(31) Paint	Semi-gloss Lacquer Azure Blue	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(32) Paint	Vinyl Phenolic Pearl White #169-W-155	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(33) Paint	Semi-gloss Lacquer Silver Blue #38-K-685	W. P. Fuller & Co. 300 So. Mission Street San Francisco, California
(34) Paint	Textured "Uni-chrome" Silver Blue #6400-248	Metal and Thermite Corp. 100 Park Avenue New York 17, New York

4. Inspection

A. General

Where doubt exists concerning serviceability of standard AN, NAS, MS parts, the part should be renewed.

B. Visual Inspection

Under strong light, preferably under magnification, visually inspect all parts as applicable, for scored or stripped threads, cracks, nicks, scratches, dents, corrosion and excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of parts.

C. Inspection Requirements

INDEX NO.	NOMENCLATURE	INSPECTION
47, 52, 56, 57, 59, 60, 61, 65, 66, 153	Fairing	Dents, gouges, wear
158	Fork	Cracks, wear
162	Clip	Cracks
122, 145, 163	Cable Assembly	Kinks, wear, broken wire, damaged housing, security of swaged ball
164, 167	Arm	Cracks, distortion
169	Actuator	Cracks, distortion
170	Shaft	Distortion, wear
5, 79, 96, 106, 118, 134, 138, 147, 168, 182, 217, 218	Pin	Wear, distortion
25, 31	Latch	Wear, sticking
12, 37, 38	Spacer	Wear, distortion
36	Table Assembly	Wear, distortion
44, 45	Bushing	Wear

INDEX NO.	NOMENCLATURE	INSPECTION
46, 259, 260	Support	Wear, distortion
74	Spring	Cracked, broken or deformed. Free length 1.00 inch.
75, 306, 307, 308	Stop	Cracks, wear
77, 254	Yoke	Cracks, wear
78	Block	Cracks, wear
81	Spring	Cracked, broken or deformed. Free length 2.75 inch.
84, 85	Lock	Operation
120, 210, 211	Spring	Cracked, broken or deformed.
121, 140	Lever	Wear
86	Ash Tray (Receiver)	Caking
109	Knob	Wear, scratches
111	Plate	Wear, scratches
89, 100	Escutcheon	Scratches
1, 48, 91, 102, 130	Cover	Rips, tears, cuts, burns, wear
50, 92, 93, 94, 103, 104, 131, 132	Pad	Wear, damage
97, 107, 123, 135, 152	Structure Assembly	Distortion, cracks, loosened nut-plates and rivets
112	Cap Assembly	Wear, scratches
136, 127	Armrest Assembly	Gouges, tears, burns
146	Spring	Cracked, broken or deformed

INDEX NO.	NOMENCLATURE	INSPECTION
150	Rod	Cracks, distortion
151	Bellcrank	Cracks, distortion
3, 49	Cushion	Wear, damage
54	Step	Distortion, cracks
177	Tube	Distortion, cracks
179, 191	Plunger	Wear, cracks
180	Driver	Wear, cracks
181, 192	Spring	Cracked, broken or deformed
183, 193	Fitting	Distortion, wear
189	Block	Wear, cracks
190	Wedge	Wear, cracks
277	Base Assembly	Distortion, cracks, loosened nut-plates and rivets
2	Pillow	Wear, damage
4	Cord	Wear, breaks
18	Clip	Cracks, breaks
20, 200, 201, 205	Washer	Cracks
16, 23	Angle	Distortion, cracks
17, 24	Channel	Distortion, cracks
28	Bracket	Distortion, cracks
290, 298	Bead	Wear
242	Fitting	Distortion, cracks
279, 280, 281	Pivot	Wear, cracks
243, 246, 250	Plate	Cracks

INDEX NO.	NOMENCLATURE	INSPECTION
249, 253	Cable	Kinks, wear, broken wire, security of swaged ball.
263, 267	Seal	Tears, cracks
264, 268	Absorber Assembly	Kinks, wear, broken wire, security of swaged ball.
283, 302	Rail	Cracks, breaks, nicks, wear
289	Cam	Distortion, cracks, nicks, wear
291	Pan	Bends, cracks, breaks
202	Triplate	Distortion, cracks, broken teeth
206, 207	Bracket	Cracks, breaks
219	Pawl	Wear, cracks, breaks
226, 227	Carpet	Wear, tears, burns, stains
269, 270, 274, 275	Socket	Distortion, cracks, breaks
293, 294, 295	Tube	Bends, cracks, breaks
297	Fairing	Bends, cracks, loosened rivets
300	Spring	Cracked, broken or deformed. Free length 1.62 inch.
311	Leg Assembly	Distortion, cracks, loosened nut-plates and rivets

5. Repair

A. General

(1) Minor nicks and scratches may be removed from aluminum alloy parts by polishing with oxide abrasive cloth specified in paragraph 3.D.(13), or equivalent. Clean all parts thoroughly after polishing.

(2) Minor nicks and scratches may be removed from non-critical steel parts by polishing with crocus cloth specified in paragraph 3.D.(14), or equivalent. Clean all parts thoroughly after polishing.

(3) Use standard shop practice for minor repair of sheetmetal and/or riveted pieces.

(4) Components not satisfying inspection requirements must be repaired before seat is returned to service or storage. Repairs are listed in the following paragraphs. Components which require inspection and are not listed in these paragraphs should be renewed if damaged or worn.

B. Cemented Foam

(1) (See IPC Figure 1.) All foam pads except seat cushions (49) are cemented to the metal structure. The cemented joint normally is stronger than the foam itself, and usually the foam will be damaged beyond use during removal operations. Foam damaged during removal should not be reinstalled. Short sections of the cemented joint can be opened and re-cemented.

(2) To remove foam for renewal use a sharp thin knife. Cut the foam close to the cemented joint while pulling foam away from the structure. Most of the foam should come off, leaving a thin layer of foam and cement on the metal. If a relatively even surface is obtained, new foam may be installed over this thin layer. If the layer is thick or uneven, strip down to bare metal before installing new foam. Use commercial grade acetone as solvent to soak layer before using a dull metal blade to scrape layer from metal.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

CAUTION: ACETONE CAUSES FOAM BREAKDOWN. DO NOT USE ACETONE IN MAKING MINOR REPAIRS. DO NOT RE-USE FOAM SOAKED BY ACETONE.

(3) If foam is torn or loose but otherwise usable, cement the tear or the loose joint. Apply cement specified in paragraph 3.D.(11), or equivalent, to both sides of joint and allow to air dry until tacky. Press joint together and hold briefly.

NOTE: There is some local stiffening of foam at cemented joints. Avoid heavy or extensive cementing on seat foam surfaces or edges.

(4) (See IPC Figure 1.) Instructions contained in paragraphs 5.B.(1), (2) and (3) apply to fairings cemented to the armrest structure. The fairings will possibly be damaged beyond use during removal. The metal must be scraped clean before a new fairing is cemented in place.

C. Fiber Strips (Velcro)

(1) Fixed strips of Velcro are cemented to the seat back and seat base structure. To remove a strip soak with acetone.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPORS AND CONTACT WITH SKIN. KEEP AWAY FROM OPEN FLAMES.

(2) To install or repair a loosened strip, wipe metal surface clean and dry. Coat metal and Velcro with cement specified in paragraph 3.D.(11), or equivalent, and allow to air dry until tacky. Press joint together and hold briefly.

(3) Velcro strips are sewn to the cover material. If short sections of Velcro are loose, repair by sewing.

D. Paint

(1) Painted areas on the seat include the food tray shell (40), the tray support assembly (42), the dummy food tray fairing (47), the leg fairing (52), the rear center hinge fairings (56) and (57), the seat back fairings (59), (60) and (61), the arm fairings (63) and (66), the center armrest fairing (118) and the recline button fairing (153).

(2) Nicks, scratches, gouges and scuff marks on these items mar the general appearance of the entire seat and should be restored to their original finish.

(3) Painted areas listed in paragraph 5.D.(1) damaged with shallow cuts and abrasions may be refinished as follows:

NOTE: Deep cuts or gouges to thermoplastic material cannot be satisfactorily repaired.

(a) Sand the damaged area lightly with abrasive cloth as specified in paragraph 3.D.(18).

NOTE: Extensive sanding of thermoplastic material removes the original "hair cell" surface texture.

(b) Clean the sanded area with a clean, lint-free cloth moistened in acetone.

WARNING: USE ACETONE IN WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF THE VAPORS AND CONTACT WITH THE SKIN. KEEP AWAY FROM OPEN FLAMES.

(c) Paint the damaged areas with finishes as specified below:

NOTE: Thermoplastic components will contain either integral or surface color. Do not locally refinish or touch-up thermoplastic material containing integral color, unless entire component is painted.

Applicable for Usage Code A-B

Paint the food tray shell (40), the food tray support assembly (42), the dummy food tray fairing (47), the leg fairing (52), the rear center hinge fairings (59), (60) and (61), the arm fairings (63) and (66) and the center armrest fairing (118) with one coat of lacquer as specified in paragraph 3.D.(29). Allow to air dry dust-free for two hours. Apply second coat of lacquer as specified in paragraph 3.D.(28).

Applicable for Usage Code C

Paint the leg fairing (52) with lacquer as specified in paragraph 3.D.(21).

Paint the food tray support assembly (42), the rear center hinge fairings (56) and (57), the seat back fairings (59), (60) and (61) and the recline button fairing (153) with one coat of paint as specified in paragraph 3.D.(22).

Paint all other visible metal surface with one coat of paint as specified in paragraph 3.D.(20).

Applicable for Usage Code D-F

Paint leg fairing (52) with one coat of lacquer as specified in paragraph 3.D.(25).

Paint food tray support assembly (42) with paint as specified in paragraph 3.D.(27).

Paint the rear center hinge fairings (56) and (57), the seat back fairings (59), (60) and (61), the recline button fairing (153) and all other visible painted surfaces with lacquer as specified in paragraph 3.D.(26).

Applicable for Usage Code G-H

Paint the food tray shell (40), the dummy food tray fairing (47) and the leg fairing (52) with lacquer as specified in paragraph 3.D.(31).

Paint the rear center hinge fairings (56) and (57), the seat back fairings (59), (60) and (61), the recline button fairing (153) and all visible painted surfaces with lacquer as specified in paragraph 3.D.(23).

Paint the food tray support assembly (42) with paint as specified in paragraph 3.D.(32).

Applicable for Usage Code J-K

Paint the food tray support assembly (42) with paint as specified in pargraph 3.D.(32).

Paint the rear center hinge fairings (56) and (57), the seat back fairings (59), (60) and (61), the recline button fairing (153) and all other visible painted surfaces with lacquer as specified in paragraph 3.D.(23).

Applicable for Usage Code L-M

Paint the food tray shell (40), the dummy food tray fairing (47), the food tray support assembly (42), the rear center hinge fairings (59), (60) and (61), the arm fairings (63) and (66), the center armrest fairing (118), the recline button fairing (153) and all visible painted metal surfaces with lacquer as specified in paragraph 3.D.(19).

Applicable for Usage Code N

Paint the food tray support assembly (42), the center armrest fairing (118) and all visible painted metal surfaces with paint as specified in paragraph 3.D.(30).

6. Assembly

A. Base Assembly (See IPC Figure 1, Sheet 5)

(1) Install leg assembly (311) using three washers (313), three bolts (312), two bolts (314), one bolt (318), one spacer (317), one washer (316) and one nut (315).

(2) Install food tray stops (306), (307) and (308), using twelve bolts (309) and twelve washers (310).

(3) Install six clips (305).

(4) Install rail (302).

(5) Install three bolts (304) and three nuts (303) in rail (302).

(6) Install ring (299) and spring (300) on pin (301). Install pin assembly.

(7) Install bead (298) on fairing (297) using cement as specified in paragraph 3.D.(12).

(8) Install four energy absorber tubes (293), (294) and (295) in base assembly with eight cotter pins (296).

(9) Install forward sockets (269) and (270) using eight screws (271), eight washers (272) and eight nuts (273).

NOTE: Applicable on usage code J-M only. Install sockets (269) and (270) using eight screws (271).

(10) Install rear sockets (274) and (275) using fours screws (276).

(11) Install three pans (291) using twleve screws (292).

(12) Install cam (289) and pin (288) in rail (283).

(13) Install rail (283) on base assembly using two bolts (286), two bolts (287), four washers (285) and four nuts (284).

(14) Install pivots (279), (280) and (281) on base assembly.

(15) Install six bushings (278) in pivots (279), (280) and (281).

(16) Install bead (290) on seat pan (291).

B. Seat Belt Fittings (See IPC Figure 1, Sheet 5)

(1) Applicable on usage code J-M.

(a) Install energy absorber plate (265) and dust seal (267) on each center absorber assembly (268).

(b) Install each center absorber assembly (268) on base assembly using two screws (266).

NOTE: Socket assemblies (269) and (270) must be installed concurrently.

(c) Install inboard and outboard absorber assemblies (264) by inserting in base assembly at aft end of inboard and outboard sides.

(d) Install cotter pin (255), washer (256), roller (258) and clevis pin (257) on each support (259) and (260).

(e) Install one dust seal (263) under each support (259) and (260).

(f) Install outboard energy absorber support (259) on seat base assembly using two screws (261) and two screws (262).

(g) Install inboard energy absorber support (260) on seat base assembly using two screws (261) and two screws (262).

(h) Install six seat belt attach yokes (254) on two absorber assemblies (264) and two center absorber assemblies (268).

(2) Applicable on usage code A-H, N.

(a) Install four seat belt cable assemblies (253) in base assembly.

(b) Install two plates (250) in seat base assembly beneath center armrest using four screws (252) and four nuts (251).

(c) Install two plates (247) on seat base assembly using four screws (247) and four screws (248).

(d) Install two plates (243) on seat base assembly using four screws (245) and four nuts (244).

(e) Install six fittings (242) on two cable assemblies (249) and four cable assemblies (253).

C. Inboard and Outboard Center Armrest Structures (See IPC Figure 1, Sheet 2)

(1) Inboard Center

(a) Install grommet (144) and route cable assembly (145) through armrest assembly (136).

(b) Install bellcrank (151), rod (150), pin (149), cotter pin, pin (147), ring (148) and spring (146).

(c) Connect lower end of cable assembly (145) to bellcrank (151).

(d) Install clamp (141) using screw (142) and spacer (146) in armrest structure (136).

(e) Install lever assembly (140) on upper end of cable assembly (145) using pin (138) and ring (139).

(f) Install inboard center armrest assembly (136) by inserting into base assembly.

(2) Install Outboard Center Armrest Assembly (127) by inserting into base assembly.

D. Seat Lock (See IPC Figure 1, Sheet 2)

(1) Install seat locks (84) and (85) in position under seat base assembly. Tighten nut at forward end of lock assembly on bracket in seat base assembly and install springs (81). Connect cable assemblies to seat lock arm between each seat lock arm and base assembly.

E. Breakover Assembly (See IPC Figure 1, Sheet 2)

(1) Assemble breakover assembly (68) by installing pin (79), yoke (77), spacer (76), stop (75), spring (74), washer (73) and bolt (72) on block assembly (80).

(2) In aft underside of seat base assembly install breakover assembly (68) on lock (84) and (85) using bolt (71), washer (70) and nut (69).

F. Foot Assembly (See IPC Figure 1, Sheet 3)

(1) Install spring (192), plunger (191), wedge (190), block (189), bolt (188), nut (187), screw (186), washers (185) and nut (184) in forward fitting (193).

(2) Install pin (182), spring (181), driver (180), plunger (179), clevis pin (178) and cotter pin in fitting (183).

(3) Install tube (177) in fittings (183) and (193) using four pins (176).

(4) Install foot assembly (172) on seat leg assembly (311) using two screws (175), two washers (174) and two nuts (173).

(5) Install fairing (52) on seat leg assembly (311) using four screws (53).

G. Stewardess Step (See IPC Figure 1, Sheet 1)

(1) Install step (54) on base assembly using two screws (55).

H. Center Recline Control (See IPC Figure 1, Sheet 3)

(1) Applicable on usage code A-B.

(a) Install three grommets (171) in base assembly. Slide shaft (170) through base assembly and located actuator (169) and install slotted pin (168).

(b) Install recline mechanism arm on shaft (170) using slotted pin. Install link and fork on recline mechanism arm.

(c) Install one cotter pin and one clevis pin on recline mechanism link and one cotter pin and one clevis pin on recline mechanism fork.

(2) Applicable on usage code C-N.

(a) Install grommets (171), shaft (170), actuator (169) and slotted pin (168).

(b) Install arm (164) on shaft (170) using bolt (166) and nut (165).

(c) Install spring (81) on recline mechanism arm (164).

(d) Install cable assembly (163) with cable support clamp (159) on seat base assembly flip (162) using bolt (161) and nut (160).

(e) Install fork (158), washer (157), clevis pin (156) and cotter pin (155) on aft end of cable assembly (163).

(f) Connect ends of cable assembly (163) to fork (158) and arm (164).

I. Inboard and Outboard Armrest Structure Assemblies (See IPC Figure 1, Sheet 2)

(1) Install each armrest structure assembly (123) and (124) on base assembly using three bolts (125), three washers (126).

J. Inboard and Outboard Recline Cable and Lever Assemblies (See IPC Figure 1, Sheet 2)

(1) Install lever assembly (121) in armrest structure assembly (123) and (124) using spring (120), pin (118) and retaining ring (119).

(2) Install cable assembly (122) using three clamps (114), three nuts (115), three washers (116) and three screws (117) in base assembly and armrest structure assemblies.

(3) Through ash tray well of armrest structure assembly (123) and (124) connect cable assembly (122) to lever assembly (121).

K. Outboard Center Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Install two washers (105) and two pins (106) in armcap structure assembly (107).

(2) Place pads (103) and (104) on armcap structure assembly (107).

(3) Install knob (109) on plate (111) using two screws (110).

(4) Install ash tray cover assembly (108) into guides on armcap structure assembly (107).

(5) Slip armrest cover (102) over armcap structure assembly (107).

(6) Install ash tray assembly (86) in cover assembly (98).

(7) Install ash tray escutcheon assembly (100) into cover assembly (98) using screw (101).

(8) Install cover assembly (98) on armrest assembly (127) by sliding cover assembly aft until fittings on underside of cover assembly mesh with slots in armrest assembly. Push top of cover assembly down to engage and slide aft.

(9) Install two screws (99).

L. Inboard Center Armrest Cover (See IPC Figure 1, Sheet 2)

(1) Install two pins (134) and two washers (133) in armcap structure assembly (135).

(2) Install top pad (131) and side pad (132) on armcap structure assembly (135).

(3) Slip cover (130) over armcap structure assembly (135).

(4) Install cover assembly (128) on armrest assembly (136) by sliding cover assembly aft until fittings on underside of cover assembly mesh with slots in armrest assembly. Push top of cover assembly down to engage and slide aft.

(5) Install two screws (129).

M. Inboard and Outboard Armrest Fairings (See IPC Figure 1, Sheet 1)

(1) Install outboard arm fairings (65) and (66) on outboard armrest structure assembly (124) using five screws (67).

(2) Install inboard armrest fairing (63) on armrest structure assembly (123) using three screws (64).

N. Inboard and Outboard Scuff Cap (See IPC Figure 1, Sheet 2)

(1) Install scuff cap (112) on armrest structure assembly (123) using screw (113).

O. Inboard and Outboard Armrest Covers (See IPC Figure 1, Sheet 2)

(1) Install two armcap pins (96) and two washers (95) on aft underside of armcap structure assembly (97).

(2) Install two inner armrest side pads (94), two outer armrest side pads (93) and top pad (92) on armcap structure assembly (97). Install armrest cover (91) over foam pads on armcap structure assembly (97).

(3) Slide ash tray cover plate (111) into guides in armrest structure assembly (123). Set ash tray knob (109) on ash tray cover plate (111) and with holes in line, install two screws (110) from bottom side of cover plate.

(4) Install ash tray escutcheon (89) on armrest cover assembly (87) using one screw (90).

(5) Install armrest cover assembly (87) on armrest structure assembly (123) by engaging cover assembly pins in structure assembly slots. Press armrest cover assembly down and slide aft until it stops.

(6) Install two screws (88) in armrest cover assembly (87).

(7) Install ash tray assembly (86) in armrest cover assembly (87) by inserting past fully-opened ash tray cover assembly (108).

P. Back Assembly (See IPC Figure 1, Sheet 1)

(1) Install latch bracket (28) and latch (25) on upper aft side of seat back structure assembly (6) using two shims (27) and two screws (26).

(2) Install channel (24), angle (23), bushing (22), shim (21), washer (20) and bushing (19) on the shorter leg of the seat back structure assembly (6).

(3) Install clip (18), channel (17), angle (16), washer (15), bushing (14), bushing (13) on the longer leg of the seat back structure assembly (6) using bolt (10), washer (11) and spacer (12), washer (9) and nut (8).

(4) Install cushion assembly (3) and pillow assembly (2) on seat back structure (6).

(5) Install cord (4) by threading through cover assembly (1).

(6) Connect literature pocket bungee cords on seat back structure assembly (6) while installing cover assembly (1) over seat back.

Q. Fairings (See IPC Figure 1, Sheet 1)

(1) Install fairing (60) on the outboard leg of the outboard seat back using four screws (62).

(2) Install fairing (61) on the inboard leg of the center seat back using four screws (62).

(3) Install fairing (59) on the inboard leg of the inboard seat back using four screws (62).

(4) Install center recline button fairing (153) on the seat base assembly (277) using three screws (154).

(5) Install fairings (57) and (56) and the aft side of the base assembly (277) using eight screws (58).

R. Inboard and Outboard Footrest (See IPC Figure 1, Sheet 4)

(1) Outboard Footrest. Applicable on usage code A, B, J, N.

(a) On outboard footrest assembly, assemble upper and lower clamshells (231) and (233) on each crossbar assembly (225) using four screws (235) and four nuts (234).

(b) Install carpet (227) over clamshells (231) and (233) and zipper locked.

(c) Position two crossbar assemblies (225) in one bracket (207) and two brackets (206).

(d) Install two pawls (219), two springs (211), two springs (210), two washers (205), two bushings (204), two bushings (203), two triplates (202) and two washers (201) in center bracket (207), using clevis pin (215), washer (213), cotter pin (212), pin (218), retaining ring (216), screw (223), washer (221), nut (220), screw (209), washer (200) and nut (199).

(e) Install pawl (219), spring (210), spring (211), washer (205), bushing (204), bushing (203), triplate (202) and washers (201) in each bracket (206), using clevis pin (214), washer (213), cotter pin (212), pin (217), retaining ring (216), screw (222), washer (211), screw (208) and nut (220) on the inboard bracket and on the outboard bracket using clevis pin (214), washer (213), cotter pin (212), pin (217), retaining ring (216), screw (222), washer (221), nut (220), screw (208), washer (200) and nut (199).

(2) Inboard Footrest. Applicable on usage code A, B, J, N.

(a) On the inboard footrest assembly, assemble upper and lower clamshells (230) and (232) on crossbar assembly (224) using four screws (235) and four nuts (234).

(b) Install carpet (226) over clamshells (230) and (232) and zipper locked.

(c) Position crossbar assembly (224) with lower footrest attached in brackets (206).

(d) Assembly following procedure outline in paragraph 6.R.(e) brackets (206).

(3) Outboard and Inboard Footrest.

(a) Install inboard footrest assembly (194) and outboard footrest assembly (195) on seat base frame using four shims (198), eight bolts (196) and eight bolts (197). Applicable on usage code J-N, only.

(b) Install inboard footrest assembly (194) and outboard footrest assembly (195) on the aft underside of seat base frame using four washers (198), four bolts (197) and twelve bolts (196). Applicable on usage code A-B, only.

S. Seat Back and Food Tray Assembly (See IPC Figure 1, Sheet 1)

(1) Applicable on usage code A-G, J, L, N. Install four bushings (44), two bushings (45) and four screws (43) in support (46).

(2) Applicable on usage code A-G, J, L, N. Install table assembly (36) on support assembly (42) using four screws (32).

(3) Applicable on usage code A-G, J, L, N. Insert latch (31) in tray assembly (36) using three screws (30

(4) Install seat back and food tray assembly or dummy fairing in base frame using pin (5).

(5) Unlatch food tray to pull tray support back and lower tray to horizontal position.

(6) Adjust tray support stops until tray pivot point is 25.5 (plus or minus 0.50) inches from the floor with both stops contacting tray support assembly (42).

(7) Adjust front set screws (43) in tray support (42) to bring top surface of food tray horizontal to floor level.

(8) Move tray installation to stowed position. If food tray does not align with tray support (42), adjust rear set screws (43) in tray support (42).

(9) Move tray installation to stowed position and insure that food tray latches positively.

(10) Add or remove shims (27) behind latch (25) until no play exists between food tray latch and seat back latch.

(11) Raise or lower latch (25) until tang of latch has positive engagement of 0.120 to 0.150 inch with food tray latch.

T. Seat Cushions (See IPC Figure 1, Sheet 1)

(1) Install pad (50) on base assembly.

(2) Install cover (48) on cushion (49) by working cover over foam. Dress to fasten Velcro on the underside with smooth and even fabric distribution all around cushion. Insure that all seams are aligned.

8. Testing

A. Seat Operation

(1) (See IPC Figure 1.) Sitting in each seat place, in turn, lift recline lever to check reclining action of seat back. Seat back must recline smoothly and lock in position when lever is released.

(2) Lean forward to take weight off seat back. Lift recline lever and check that back recovers to normal position.

(3) Repeat operations described in steps (1) and (2) at least three times.

(4) Set seat back in reclined position. With recline lever down, check that seat back can be manually returned to normal position without undue force. Check that seat back locks in normal position.

(5) Apply 35 pounds forward pull at top center of seat back and check that breakover mechanism releases to allow seat to fold forward. If necessary, adjust bolt at breakover mechanism to adjust compression of spring until correct setting is obtained.

(6) Check operation and position of food tray in open and closed positions. If necessary, adjust as described in paragraphs 6.R.(5) to (11).

9. Trouble Shooting

PASSENGER SEAT ASSEMBLY - TROUBLE SHOOTING

PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
A. Recline Handle Will Not Lift, or Lifts But Fails to Unlock Seat Back	
(1) Defective seat lock. (See IPC Figure 1.) (Sheet 2)	Replace seat lock unit.
(2) Broken or sticking elements in cable and linkage between lever and seat lock. (See IPC Figure 1.) (Sheet 2)	Check lever, clevis, turnbuckle, upper end of cable and nylon tube for bind or breakage. Look up under seat base to observe arm at front of seat lock. Move lever and insure linkage and cable move with it. Free or replace parts as necessary.
B. Recline Lever Sticks in Raised Position	
(1) Defective spring at seat lock. (See IPC Figure 1.) (Sheet 2)	Check through base structure channel for loose, stretched or broken spring. Rectify.
(2) Cable assembly binding.	Check for binding at lower end of cable. Check for binding at upper end of cable. Rectify binding condition.
C. Seat Back Fails to Lock or Recover When Seat Lock Operated	
(1) Defective seat lock. (See IPC Figure 1.) (Sheet 2)	Replace seat lock.
D. Food Tray Fails to Latch Closed	
(1) Defective tray latch (31). (See IPC Figure 1.) (Sheet 1)	Check tray latch operation. Replace tray latch (31).
(2) Defective seat latch (25). (See IPC Figure 1.) (Sheet 1)	Check seat latch operation. Replace seat latch (25).
(3) Maladjusted latches.	Check latch adjustment; refer to paragraphs 6.R.(9) to (11). Adjust if necessary.

PASSENGER SEAT ASSEMBLY - TROUBLE SHOOTING

	PROBABLE CAUSE	ISOLATION PROCEDURE AND CORRECTION
(4)	Food tray pivot distorted or sheared. (See IPC Figure 1.) (Sheet 1)	Replace food tray assembly.

E. Food Tray Not Level in Down Position

(1)	Food tray support stops (306), (307) and (308). (See IPC Figure 1.) (Sheet 5)	Loosen bolts (309) and adjust stops (306), (307) and (308); refer to paragraph 6.R.(5) to (7).

F. Seat Back Folds Forward Past Normal Position With Light Push

(1)	Maladjusted breakover assembly. (See IPC Figure 1.) (Sheet 2)	Check breakover adjustment; refer to paragraph 8.A.(5).
(2)	Broken breakover assembly.	Check breakover assembly for obvious damage. Replace breakover assembly if necessary.

G. Seat Back Fails to Fold Forward on Impact

(1)	Maladjusted breakover assembly. (See IPC Figure 1.) (Sheet 2)	Check breakover adjustment; refer to paragraph 8.A.(5).

H. Footrest Will Not Lift, or Lifts But Fails to Lock

(1)	Broken or sticking elements in footrest assembly at upper pivot. (See IPC Figure 1.) (Sheet 4)	Check footrest ratchet pawl (219) and footrest ratchet triplate for bind or breakage. Free or replace parts as necessary

J. Footrest Crossbar Pivots Without Locking

(1)	Broken pin stop on crossbar assembly (224) and (225). (See IPC Figure 1.) (Sheet 4)	Replace crossbar assembly.

10. Storage Instructions

A. The seat assembly is essentially corrosion resistant and no special preservation is required.

B. For maximum space in storage, demount seat back and tray group and center arm rests. Keep removed parts with applicable assembly.

C. Wrap seat in waterproof wrapping paper specified in paragraph 3.D.(16), or a plastic cover. Use tape specified in paragraph 3.D.(17), or equivalent, to secure wrapping paper or cover. Stamp seat assembly part number and date of overhaul on a tag or in a convenient location on seat wrapper.

D. Store seat in a cool dry area below 68 degrees F, away from sunlight and heat source.

11. Special Tools, Fixtures and Equipment

A. While not essential, a frame or fixture to simulate the mounting provisions in the airplane will assist disassembly and assembly.

B. No other special tools, fixtures or equipment are required.

AFT ATTENDANT'S AFT FACING SEAT - STA 1378
(Convair Part No. 22-93513-809 and -3)

ATA NO. 25-3-2

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Models 30-5 and 30-8. Mar. 31/62

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Chapter 25

AFT ATTENDANTS AFT FACING SEAT, STA 1378
(Convair Part No. 22-93513-803 and -3)

1. Description and Operation

A. Description.

(1) The aft facing attendants seat is mounted on the left bulkhead, just forward of the aft, main entrance door. The seat back consists of a foam rubber cushion cemented to a fiberglass backing. A naugahyde, tailored cover, placed over the cushion, is cemented to the aft side of the fiberglass backing. Press-type studs, installed in the fiberglass backing, attach the top of the seat back to the airplane bulkhead. Button-type snaps, attached to a flap on the cushion cover, anchor the bottom of the seat back to the airplane structure.

(2) The seat bottom is of cantilever construction and pivots on two bolts that allow it to be folded upward against the seat back for stowage. A foam rubber cushion, cemented to the upper side of the contoured seat pan, is covered with naugahyde, tailored to fit the seat. The cover is attached to the seat pan with screws and washers. A boltaron fairing, cemented to the lower side of the seat pan, provides a smooth lower surface.

(3) An over-hang, on the aft side of the seat bottom, is provided with an attachment for a tension-type spring. The tension spring, attached to the seat and floor of the airplane, positions the seat bottom in the stowed position when the seat is not occupied. If the seat is occupied, the aft, over-hang section of the seat pan bottoms against the airplane, bulkhead structure to provide support. Each side of the seat is provided with attachments for a safety belt. A bracket, on the bulkhead above the seat back, provides an attachment for the shoulder harness to the airplane structure.

B. Leading Particulars.

(1) Seat Bottom Dimensions:

(a) Length (front to back).....25.54 inches.

(b) Width.....19.33 inches.

(c) Thickness (maximum).....4.25 inches.

(2) Seat Back Dimensions:

(a) Height.....10.80 inches.

(b) Width.....19.12 inches.

(c) Thickness.....1.62 inches.

C. Operation.

(1) The attendants aft facing, aft seat is attached to the airplane structure. The seat bottom is pivoted at the two attaching points to the airplane bulkhead. An extension of the seat structure, aft of the pivot point, supports the seat bottom whenever the seat is occupied. A tension-type spring, attached to the airplane structure and the aft over-hang portion of the seat, provides automatic stowage when the seat is not occupied.

2. Disassembly

(See IPC Figure 1.) The attendants seat cannot be removed from the airplane as an assembly. The seat back and seat bottom are separate components. Attaching parts for the seat bottom, safety belt and shoulder harness will accompany the main components to the overhaul shop. Disassemble components as follows:

A. Seat Back.

(1) Separate cover (2) and cushion (4) from backing (5).

NOTE: Cover (2) and cushion (4) are tacked to backing (5) with adhesive cement to facilitate installation and retain contour during use. Use a sharp, blade-type instrument to separate components.

(2) Remove four studs (6), spacers (7) and screws (8) from backing (5).

(3) If replacement is necessary, remove three buttons (3) from cover (2).

B. Seat Bottom.

(1) Remove eleven screws (10) and washers (11), and unsnap four buttons (12) to remove cover (9) from seat structure (16).

(2) If replacement is necessary, remove four buttons (12) from cover (9) and four sockets (13) from structure (16).

(3) Separate cushion (15) from seat structure (16).

NOTE: Cushion (15) is tacked to structure (16) with adhesive cement to facilitate installation and retain contour during use. Use a sharp, blade-type instrument to separate components.

(4) If replacement is necessary, remove two bushings (25) from structure (16).

(5) Remove two nuts (27), two washers (28), two bolts (29) and two rivets (30) to remove filler (31) and tee (26) from structure (16).

(6) Remove two washers (20) from each of four rivets (23) and remove one half of the link from each of the two links (24).

(7) Remove one washer (21) from one rivet (23) on each of two links (24).

(8) Remove two bushings (22) from two rivets (23) on each of two links (24).

(9) Remove two rivets (23) and the remaining half of two links (24) from each side of structure (16).

(10) Remove two washers (21) from each of two rivets (23).

NOTE: Do not separate boltaron fairing (32) from seat pan (33) unless complete replacement of fairing (32) is necessary. These two components are cemented together and fairing (32) will be destroyed during the separation process.

3. Cleaning

A. General.

(1) (See IPC Figure 1.) Wipe all painted metal parts with a clean, lint-free cloth moistened with cleaning solvent recommended in paragraph 6.C.(1). Unpainted metal parts may be submerged in cleaning solvent and scrubbed as necessary. Dry all parts thoroughly with filtered, moisture-free air and a clean, lint-free cloth.

WARNING: USE SOLVENT IN A WELL VENTILATED AREA. AVOID PROLONGED INHALATION OF SOLVENT FUMES. KEEP SOLVENT AWAY FROM OPEN FLAME.

(2) Clean seat covers (2) and (9) with a cloth dampened in a soap and water solution. Use soap recommended in paragraph 6.C.(11). Wipe surface clean with a cloth dampened in cold water and dry thoroughly with a clean, lint-free cloth. Dissolve adhesive cement with solvent recommended in paragraph 6.C.(5).

(3) Cushions (4) and (15) may be washed in a mild soap and water solution. Use soap recommended in paragraph 6.C.(11). Rinse in cold water, squeeze gently and air-dry thoroughly.

(4) Clean the surface of boltaron fairing (32) with a soap and water solution. Use soap recommended in paragraph 6.C.(11). Wipe surface clean with a cloth moistened in cold water and dry thoroughly with a clean lint free cloth. To clean heavily soiled areas, moisten a clean, lint-free cloth with solvent recommended in paragraph 6.C.(9).

(5) Safety belt (35) and shoulder harness (36) should be cleaned in accordance with instructions in CONVAIR MODEL 30 MAINTENANCE MANUAL, Chapter 25-0, EQUIPMENT AND FURNISHINGS.

(6) To dissolve adhesive, cement deposits from seat pan (33) or to separate seat pan (33) and boltaron fairing (32), use solution, recommended in paragraph 6.C.(7).

(7) Dissolve adhesive cement from seat backing (5) with solution recommended in paragraph 6.C.(5).

4. Inspection

A. General.

(1) Under a strong light, preferably under magnification, inspect all parts, as applicable, for nicks, cracks, cuts, dents, scratches, corrosion, crossed or stripped threads, chafing, scoring or excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of a part.

(2) Replace all parts that fail to meet inspection requirements.

(3) Where doubt exists concerning the serviceability of standard AN, NAS, NAF or MS parts, renew the part.

B. Component Inspection.

Visually inspect all parts as directed in paragrap 4.A.

C. Special Component Inspection.

IPC FIG & INDEX NO.	NOMENCLATURE	INSPECTION
1-34	Spring	27 (±2) pounds tension load; 13.0 inches length. 58 (±2) pounds tension load; 17.7 inches length. Visual for cracks, distortion, corrosion.
-35	Safety belt	Visual for wear, damage (particular attention at attachment points), correct operation. Weight test.
-36	Safety harness	Visual for wear, damage (particular attention at attachment points), correct operation. Weight test.

D. Replace all components that fail to meet inspection requirements.

5. Repair

A. Replace covers (2) or (9) or boltaron fairing (32) if they are damaged beyond cleaning or where a repair would make the cover appear to be sub-standard.

B. If it is necessary to repair boltaron fairing (32), refer to instructions in CONVAIR MODEL 30 MAINTENANCE MANUAL, Chapter 25-0, EQUIPMENT AND FURNISHINGS.

C. Remove minor nicks and scratches from aluminum alloy parts by polishing with material recommended in paragraph 6.C.(2).

D. Remove minor nicks and scratches from steel parts by polishing with material recommended in paragraph 6.C.(3).

CAUTION: EXCESSIVE USE OF ABRASIVES CAN DAMAGE PLATED SURFACES.

E. Refer to paragraph 3. for cleaning instructions after repair.

F. If coating on painted surfaces has been damaged, or removed to facilitate inspection processes or repair, restore original finish.

6. Assembly

(See IPC Figure 1.) Assemble components of the attendants seat as follows:

A. Seat Back.

(1) Attach four screws (8), spacers (7) and studs (6) to backing (5).

(2) Tack cushion (4) to backing (5) with adhesive cement recommended in paragraph 6.C.(4) or 6.C.(6).

(3) Install three buttons (3) in cover (2).

(4) Position cover (2) over cushion (4) and attach top and side flaps to aft side of backing (5) with adhesive cement, recommended in paragraph 6.C.(4) or 6.C.(6).

B. Seat Bottom.

(1) Attach boltaron fairing (32) to seat pan (33) with adhesive cement recommended in paragraph 6.C.(8) or 6.C.(6).

(2) Install one bushing (22) in holes provided in plates on each side of structure (16).

(3) Attach two links (24) to seat structure (16) by inserting one rivet (23) through one half of link (24), one washer (21), one bushing (22), one washer (21), one half of link (24), and one washer (20) on each side of structure (16). Buck rivets.

(4) Provide attachment for safety belt on opposite end of each link (24) by inserting one rivet (23) through half of link (24), one bushing (22), one half of link (24) and one washer (20) on each side of structure (16). Buck rivets.

(5) Position filler (31) on aft side of structure (16). Place tee (26) on top of filler (31) and attach to structure (16) with two rivets (30), two bolts (29), two washers (28) and two nuts (27).

(6) Install one bushing (25) on each side of structure (16).

(7) Install four sockets (13) in structure (16) and four buttons (12) in cover (9).

(8) Tack cushion (15) to structure (16) with cement recommended in paragraph 6.C.(4) or 6.C.(6).

(9) Place cover (9) over cushion (15) and attach to structure (16) with four buttons (12), eleven washers (11) and eleven screws (10).

(10) Bag and tag loose items (17), (18), (19), (34), (35), and (36), and secure to seat bottom.

C. Materials.

Use materials listed or equivalent.

	MATERIAL	IDENTIFICATION	SOURCE
(1)	Cleaning Solvent	Federal Specification P-S-661	Optional
(2)	Aluminum Oxide Abrasive Cloth	Federal Specification P-C-451	Optional
(3)	Crocus Abrasive Cloth	Federal Specification P-C-458	Optional
(4)	Cement, Stabond	Stabond T-161	American Latex Products Corporation, Los Angeles, California
(5)	Thinner, Toluene	Federal Specification TT-T-548	Optional

MATERIAL	IDENTIFICATION	SOURCE
(6) Cement	EC-870	Minnesota Mining and Manufacturing Company St. Paul, Minnesota
(7) Solvent, Methyl Ethyl Ketone	Federal Specification TT-M-261	Optional
(8) Adhesive, Epoxy	Narmco 3135 Resin	Narmco Resins and Coating San Diego, California
(9) Naptha Aliphatic	Federal Specification TT-N-95	Optional
(10) Wrapping Paper	Federal Specification UU-P-271	Optional
(11) Soap, Cleaning	Castile	Optional

7. Fits and Clearances

Not applicable

8. Testing

(See IPC Figure 1.) Test safety belt (35) and shoulder harness (36) in accordance with current FAA requirements.

9. Trouble Shooting

Not applicable

10. Storage Instructions

A. Wrap all components in paper, recommended in paragraph 6.C.(10) and seal with tape.

B. Stamp the part number and overhaul date on a tag, and attach to components or stamp the information in a convenient location on the outside of the package.

C. Store in a cool dry area, away from sunlight and heat sources. Maintain room temperature between 60 to 80 degrees F.

11. Special Tools, Fixtures and Equipment

Not applicable

ILLUSTRATED PARTS BREAKDOWN

AFT ATTENDANT'S AFT FACING SEAT - STA 1378
(Convair Part No. 22-93513-809 and -3)

ATA NO. 25-3-2

Applicable to Models 30-5 and 30-8. Mar. 31/62

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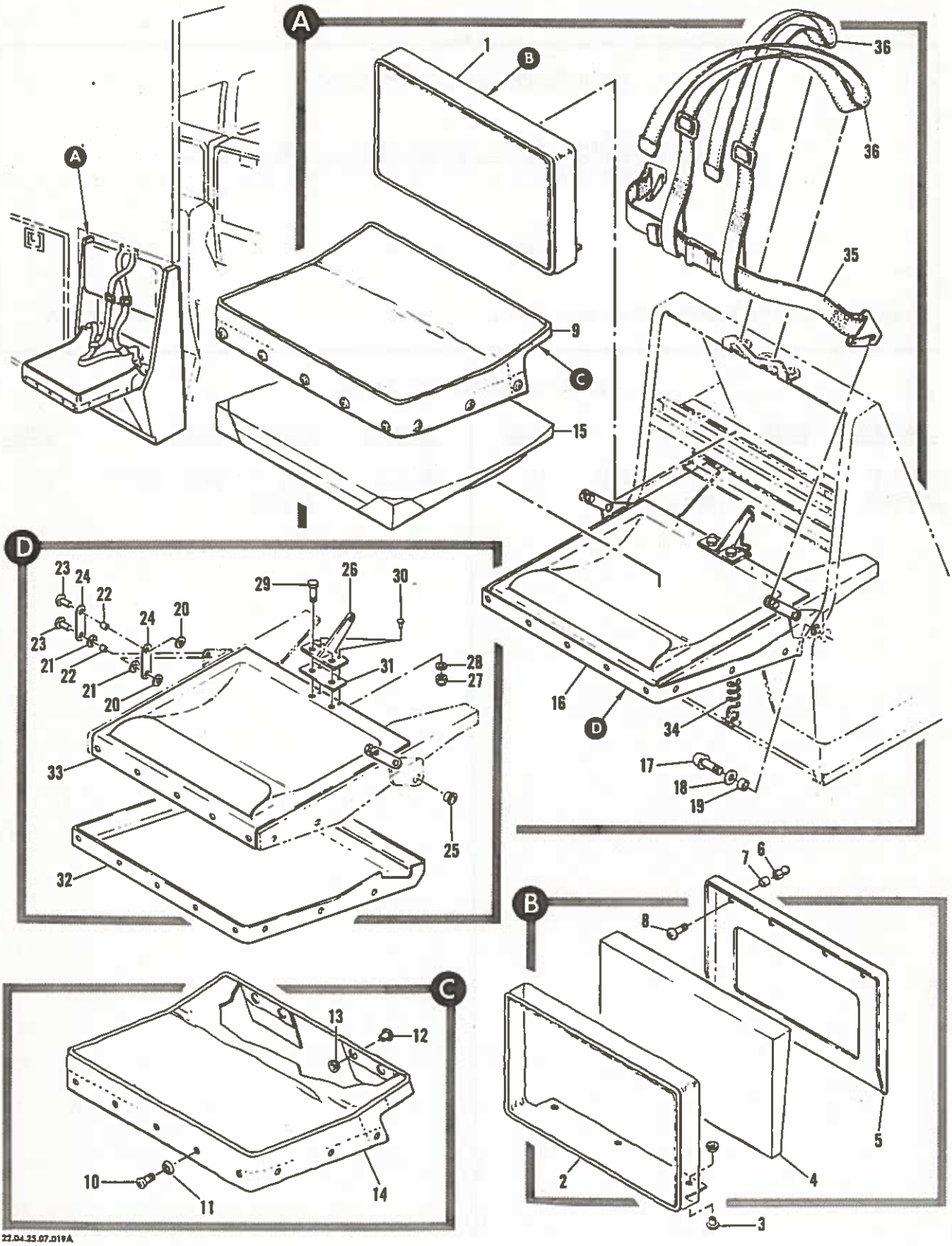

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1	22-93513-809	SEAT INSTALLATION, AFT FACING AFT ATTENDANT	1		REF
	22-93513-3	SEAT INSTALLATION, AFT FACING AFT ATTENDANT	1		REF
- 1	22-93503-7	. CUSHION ASSEMBLY, SEAT BACK	1		1
- 2	22-93516-1	. . COVER ASSEMBLY, STITCHED	1		1
- 3	AN227-11	. . BUTTON	1		3
- 4	22-93517-17	. . CUSHION, SEAT BACK, BONDED	1		1
- 5	22-93553-7	. . BACKING, SEAT	1		1
		ATTACHING PARTS			
- 6	P101-421	. . STUD, CONVAIR 98-55600-002 -V78553-	1		4
- 7	NAS43DD1-5	. . SPACER	1		4
- 8	AS515-6R5	. . SCREW	1		4
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- 9	22-93516-5	. COVER ASSEMBLY, SEAT BOTTOM	1		1
- 10	8-32NC2A	. . SCREW, CONVAIR 97-89025-013 -V42689	1		11
- 11	61-3208	. . WASHER, CONVAIR 99-51405-001 -V42689-	1		11
- 12	AN227-11	. . BUTTON	1		4
- 13	AN227-12	. . SOCKET	1		4
	22-93516-23	. . RETAINER	1		2
	22-93516-21	. . RETAINER	1		1
	22-93516-45	. . STRIP, TAB	1		2
- 14	22-93516-33	. . TOP	1		1
- 15	22-93517-5	. CUSHION, SEAT BOTTOM, BONDED	1		1
- 16	22-93510-1	. STRUCTURE ASSEMBLY, ATTENDANT SEAT	1		1
		ATTACHING PARTS			
- 17	MS20005-22	. BOLT	1		2
- 18	MS20002C5	. WASHER	1		2
- 19	NAS43HT5-16	. SPACER	1		2
		----X----			
- 20	AN960C10L	. . WASHER	1		4
- 21	AN960C516L	. . WASHER	1		4
- 22	91-27004-038	. . BUSHING	1		4
- 23	Q4310	. . RIVET, CONVAIR 97-67002-078	1		4
- 24	22-93510-43	. . LINK	1		4
- 25	NAS77-7-12	. . BUSHING	1		2
	22-93510-41	. . PLATE, LH, RIVETED	1		1
	22-93510-42	. . PLATE, RH, RIVETED	1		1
- 26	22-93510-55	. . TEE	1		1
		ATTACHING PARTS			
- 27	NAS679A3	. . NUT	1		2
- 28	AN960D10L	. . WASHER	1		2
- 29	NAS1103-3	. . BOLT	1		2
- 30	AN470AD5	. . RIVET	1		2
		----X----			
- 31	22-93510-51	. . FILLER	1		1
- 32	22-93523-1	. . FAIRING ASSEMBLY, SEAT BOTTOM BONDED	1		1
- 33	22-93510-15	. . PAN, SEAT BOTTOM, RIVETED	1		1
- 34	22-93557-7	. SPRING	1		1
- 35	BN1-1513A15-22-1370	. BELT, SAFETY, CONVAIR 90-63801-013 -V01345- USED ON 22-93513-809 ONLY	1		1
	1008H	. BELT SAFETY, CONVAIR 90-63801-030 -V00652- USED ON 22-93513-3 ONLY	1		1
- 36	BN1-1514-1	. HARNESS, SAFETY, CONVAIR 94-58000-011 - V01345- USED ON 22-93513-809 ONLY	1		1

FORWARD ATTENDANT'S AFT FACING SEAT
(Convair Part No. 22-93503-805)

ATA NO. 25-3-3

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Model 30-6.

July 25/62

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Chapter 25

FORWARD ATTENDANT'S AFT FACING SEAT
(Convair Part No. 22-93503-805)

1. Description and Operation

A. Description.

(1) The forward attendant's aft facing seat is mounted on the left bulkhead, just forward of the main entrance door. The seat back consists of a foam rubber cushion cemented to a fiberglass backing. A naugahyde, tailored cover, placed over the cushion, is cemented to the aft side of the fiberglass backing. Press-type studs, installed in the fiberglass backing, attach the top of the seat back to the airplane bulkhead. Button-type snaps, attached to a flap on the cushion cover, anchor the bottom of the seat back to the airplane structure.

(2) The seat bottom is of cantilever construction and pivots on two bolts that allow it to be folded upward against the seat back for stowage. A foam rubber cushion, cemented to the upper side of the contoured seat pan, is covered with naugahyde, tailored to fit the seat. The cover is attached to the seat pan with screws and washers. A boltaron fairing, cemented to the lower side of the seat pan, provides a smooth lower surface.

(3) An over-hang, on the aft side of the seat bottom, is provided with an attachment for a tension-type spring. The tension spring, attached to the seat and floor of the airplane, positions the seat bottom in the stowed position when the seat is not occupied. If the seat is occupied, the aft, over-hang section of the seat pan bottoms against the airplane, bulkhead structure to provide support. Each side of the seat is provided with attachments for a safety belt.

B. Leading Particulars.

(1) Seat Bottom Dimensions:

(a) Length (front to back).....25.54 inches.

(b) Width.....19.33 inches.

(c) Thickness (maximum).....4.25 inches.

(2) Seat Back Dimensions:

(a) Height.....10.80 inches.

(b) Width.....19.12 inches.

(c) Thickness.....1.62 inches.

C. Operation.

(1) The forward attendant's aft facing seat is attached to the airplane structure. The seat bottom is pivoted at the two attaching points to the airplane bulkhead. An extension of the seat structure, aft of the pivot point, supports the seat bottom whenever the seat is occupied. A tension-type spring, attached to the airplane structure and the aft over-hang portion of the seat, provides automatic stowage when the seat is not occupied.

2. Disassembly

(See IPC Figure 1.) The attendants seat cannot be removed from the airplane as an assembly. The seat back and seat bottom are separate components. Attaching parts for the seat bottom and safety belt will accompany the main components to the overhaul shop. Disassemble components as follows:

A. Seat Back.

(1) Separate cover (2) and cushion (4) from backing (5).

NOTE: Cover (2) and cushion (4) are tacked to backing (5) with adhesive cement to facilitate installation and retain contour during use. Use a sharp, blade-type instrument to separate components.

(2) Remove four studs (6), spacers (7) and screws (8) from backing (5).

(3) If replacement is necessary, remove three buttons (3) from cover (2).

B. Seat Bottom.

(1) Remove eleven screws (10) and washers (11), and unsnap four buttons (12) to remove cover (9) from seat structure (16).

(2) If replacement is necessary, remove four buttons (12) from cover (9) and four sockets (13) from structure (16).

(3) Separate cushion (15) from seat structure (16).

NOTE: Cushion (15) is tacked to structure (16) with adhesive cement to facilitate installation and retain contour during use. Use a sharp, blade-type instrument to separate components.

(4) If replacement is necessary, remove two bushings (25) from structure (16).

(5) Remove two nuts (27), two washers (28), two bolts (29) and two rivets (30) to remove filler (31) and tee (26) from structure (16).

(6) Remove two washers (20) from each of four rivets (23) and remove one half of the link from each of the two links (24).

(7) Remove one washer (21) from one rivet (23) on each of two links (24).

(8) Remove two bushings (22) from two rivets (23) on each of two links (24).

(9) Remove two rivets (23) and the remaining half of two links (24) from each side of structure (16).

(10) Remove two washers (21) from each of two rivets (23).

NOTE: Do not separate boltaron fairing (32) from seat pan (33) unless complete replacement of the fairing is necessary. These two components are cemented together and fairing may be destroyed during the separation process.

3. Cleaning

A. General.

(1) (See IPC Figure 1.) Wipe all painted metal parts with a clean, lint-free cloth moistened with cleaning solvent recommended in paragraph 6.C.(1). Unpainted metal parts may be submerged in cleaning solvent and scrubbed as necessary. Dry all parts thoroughly with filtered, moisture-free air and a clean, lint-free cloth.

WARNING: USE SOLVENT IN A WELL VENTILATED AREA. AVOID PROLONGED INHALATION OF SOLVENT FUMES. KEEP SOLVENT AWAY FROM OPEN FLAME.

(2) Clean seat covers (2) and (9) with a cloth dampened in a soap and water solution. Use soap recommended in paragraph 6.C.(11). Wipe surface clean with a cloth dampened in cold water and dry thoroughly with a clean, lint-free cloth. Dissolve adhesive cement with solvent recommended in paragraph 6.C.(5).

(3) Cushions (4) and (15) may be washed in a mild soap and water solution. Use soap recommended in paragraph 6.C.(11). Rinse in cold water, squeeze gently and air-dry thoroughly.

(4) Clean the surface of boltaron fairing (32) with a soap and water solution. Use soap recommended in paragraph 6.C.(11). Wipe surface clean with a cloth moistened in cold water and dry thoroughly with a clean lint free cloth. To clean heavily soiled areas, moisten a clean, lint-free cloth with solvent recommended in paragraph 6.C.(9).

(5) Safety belt (35) should be cleaned in accordance with instructions in CONVAIR MODEL 30 MAINTENANCE MANUAL, Chapter 25-0, EQUIPMENT AND FURNISHINGS.

(6) To dissolve adhesive, cement deposits from seat pan (33) or to separate seat pan (33) and boltaron fairing (32), use solution, recommended in paragraph 6.C.(7).

(7) Dissolve adhesive cement from seat backing (5) with solution recommended in paragraph 6.C.(5).

4. Inspection

A. General.

(1) Under a strong light, preferably under magnification, inspect all parts, as applicable, for nicks, cracks, cuts, dents, scratches, corrosion, crossed or stripped threads, chafing, scoring or excessive wear.

NOTE: Excessive wear is defined as any obvious deformation or deterioration of a part.

(2) Replace all parts that fail to meet inspection requirements.

(3) Where doubt exists concerning the serviceability of standard AN, NAS, NAF or MS parts, renew the part.

B. Component Inspection.

Visually inspect all parts as directed in paragraph 4.A.

C. Special Component Inspection.

IPC FIG & INDEX NO.	NOMENCLATURE	INSPECTION
1-34	Spring	27 (±2) pounds tension load; 13.0 inches length.
		58 (±2) pounds tension load; 17.7 inches length.
		Visual for cracks, distortion, corrosion.
-35	Safety belt	Visual for wear, damage (particular attention at attachment points), correct operation. Weight test.

D. Replace all components that fail to meet inspection requirements.

5. Repair

A. Replace covers (2) or (9) or boltaron fairing (32) if they are damaged beyond cleaning or where a repair would make the cover appear to be sub-standard.

B. If it is necessary to repair boltaron fairing, refer to instructions in CONVAIR MODEL 30 MAINTENANCE MANUAL, Chapter 25-0, EQUIPMENT AND FURNISHINGS.

C. Remove minor nicks and scratches from aluminum alloy parts by polishing with material recommended in paragraph 6.C.(2).

D. Remove minor nicks and scratches from steel parts by polishing with material recommended in paragraph 6.C.(3).

CAUTION: EXCESSIVE USE OF ABRASIVES CAN DAMAGE PLATED SURFACES.

E. Refer to paragraph 3., for cleaning instructions after repair.

F. If coating on painted surfaces has been damaged, or removed to facilitate inspection processes or repair, restore original finish.

6. Assembly

(See IPC Figure 1.) Assemble as follows:

A. Seat Back.

(1) Attach four screws (8), spacers (7) and studs (6) to backing (5).

(2) Tack cushion (4) to backing (5) with adhesive cement recommended in paragraph 6.C.(4) or 6.C.(6).

(3) Install three buttons (3) in cover (2).

(4) Position cover (2) over cushion (4) and attach top and side flaps to aft side of backing (5) with adhesive cement, recommended in paragraph 6.C.(4) or 6.C.(6).

B. Seat Bottom.

(1) Attach boltaron fairing (32) to seat pan (33) with adhesive cement recommended in paragraph 6.C.(8) or 6.C.(6).

(2) Install one bushing (22) in holes provided in plates on each side of structure (16).

(3) Attach two links (24) to seat structure (16) by inserting one rivet (23) through one half of link (24), one washer (21), one bushing (22), one washer (21), one half of link (24), and one washer (20) on each side of structure (16). Buck rivets.

(4) Provide attachment for safety belt on opposite end of each link (24) by inserting one rivet (23) through half of link (24), one bushing (22), one half of link (24) and one washer (20) on each side of structure (16). Buck rivets.

(5) Position filler (31) on aft side of structure (16). Place tee (26) on top of filler (31) and attach to structure (16) with two rivets (30), two bolts (29), two washers (28) and two nuts (27).

(6) Install one bushing (25) on each side of structure (16).

(7) Install four sockets (13) in structure (16) and four buttons (12) in cover (9).

(8) Tack cushion (15) to structure (16) with cement recommended in paragraph 6.C.(4) or 6.C.(6).

(9) Place cover (9) over cushion (15) and attach to structure (16) with four buttons (12), eleven washers (11) and eleven screws (10).

(10) Bag and tag loose items (17), (18), (19), (34) and (35) and secure to seat bottom.

C. Materials.

Use materials listed or equivalent.

	MATERIAL	IDENTIFICATION	SOURCE
(1)	Cleaning Solvent	Federal Specification P-S-661	Optional
(2)	Aluminum Oxide Abrasive Cloth	Federal Specification P-C-451	Optional
(3)	Crocus Abrasive Cloth	Federal Specification P-C-458	Optional
(4)	Cement, Stabond	Stabond T-161	American Latex Products Corporation, Los Angeles, California
(5)	Thinner, Toluene	Federal Specification TT-T-548	Optional

MATERIAL	IDENTIFICATION	SOURCE
(6) Cement	EC-870	Minnesota Mining and Manufacturing Company St. Paul, Minnesota
(7) Solvent, Methyl Ethyl Ketone	Federal Specification TT-M-261	Optional
(8) Adhesive, Epoxy	Narmco 3135 Resin	Narmco Resins and Coating San Diego, California
(9) Naptha Aliphatic	Federal Specification TT-N-95	Optional
(10) Wrapping Paper	Federal Specification UU-P-271	Optional
(11) Soap, Cleaning	Castile	Optional

7. Fits and Clearances

Not applicable

8. Testing

(See IPC Figure 1.) Test safety belt (35) in accordance with current FAA requirements.

9. Trouble Shooting

Not applicable

10. Storage Instructions

A. Wrap all components in paper, recommended in paragraph 6.C.(10) and seal with tape.

B. Stamp the part number and overhaul date on a tag, and attach to components or stamp the information in a convenient location on the outside of the package.

C. Store in a cool dry area, away from sunlight and heat sources. Maintain room temperature between 60 to 80 degrees F.

11. Special Tools, Fixtures and Equipment

Not applicable

ILLUSTRATED PARTS BREAKDOWN

FORWARD ATTENDANT'S AFT FACING SEAT
(Convair Part No. 22-93503-805)

ATA NO. 25-3-3

Applicable to Model 30-6. July 25/62

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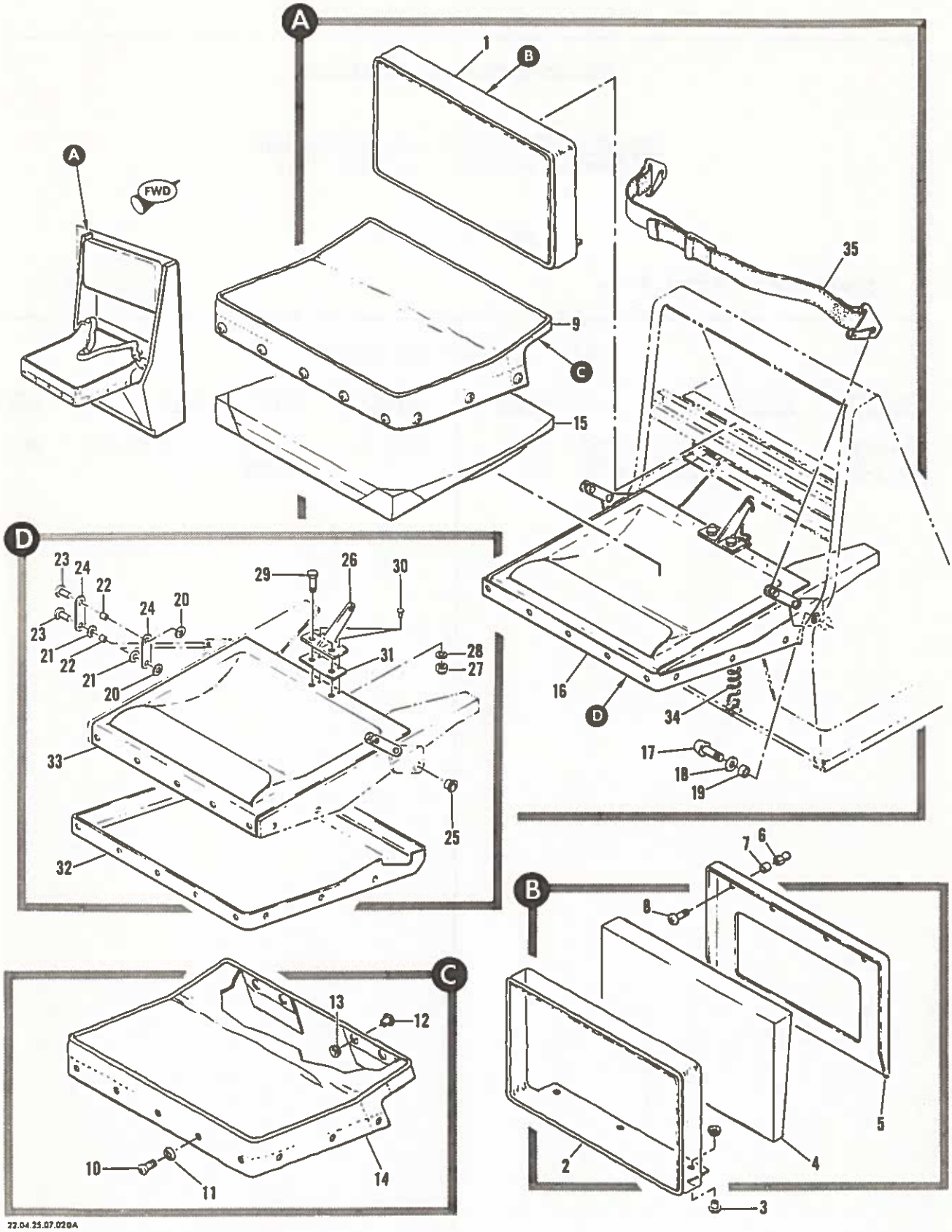

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1	22-93503-805	SEAT INSTALLATION, AFT FACING FWD ATTENDANT	1		REF
	22-93516-48	. COVER, SAFETY BELT ATTACHMENT	1		1
- 1	22-93503-7	. CUSHION ASSEMBLY, SEAT BACK	1		1
- 2	22-93516-1	. . COVER ASSEMBLY, STITCHED	1		1
- 3	AN227-11	. . BUTTON	1		3
- 4	22-93517-17	. . CUSHION, SEAT BACK, BONDED	1		1
- 5	22-93553-7	. . BACKING, SEAT	1		1
		ATTACHING PARTS			
- 6	P101-421	. . STUD, CONVAIR 98-55600-002 -V78553-	1		4
- 7	NAS43DD1-5	. . SPACER	1		4
- 8	AN515-6R5	. . SCREW	1		4
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- 9	22-93516-5	. COVER ASSEMBLY, SEAT BOTTOM	1		1
-10	8-32NC2A	. . SCREW, CONVAIR 97-89025-013 -V42689-	1		11
-11	61-3208	. . WASHER, CONVAIR 99-51405-001 -V42689-	1		11
-12	AN227-11	. . BUTTON	1		4
-13	AN227-12	. . SOCKET	1		4
	22-93516-23	. . RETAINER	1		2
	22-93516-21	. . RETAINER	1		1
	22-93516-45	. . STRIP, TAB	1		2
-14	22-93516-33	. . TOP	1		1
-15	22-93517-5	. CUSHION, SEAT BOTTOM, BONDED	1		1
-16	22-93510-1	. STRUCTURE ASSEMBLY, ATTENDANT SEAT	1		1
		ATTACHING PARTS			
-17	MS20005-22	. BOLT	1		2
-18	MS20002C5	. WASHER	1		2
-19	NAS43HT5-16	. SPACER	1		2
		----X----			
-20	AN960C10L	. . WASHER	1		4
-21	AN960C516L	. . WASHER	1		4
-22	91-27004-038	. . BUSHING	1		4
-23	Q4310C6-8	. . RIVET, CONVAIR 97-67002-078	1		4
-24	22-93510-43	. . LINK	1		4
-25	NAS77-7-12	. . BUSHING	1		2
	22-93510-41	. . PLATE, LH, RIVETED	1		1
	22-93510-42	. . PLATE, RH, RIVETED	1		1
-26	22-93510-55	. . TEE	1		1
		ATTACHING PARTS			
-27	NAS679A3	. . NUT	1		2
-28	AN960D10L	. . WASHER	1		2
-29	NAS1103-3	. . BOLT	1		2
-30	AN470AD5	. . RIVET	1		2
		----X----			
-31	22-93510-51	. . FILLER	1		1
-32	22-93523-1	. . FAIRING ASSEMBLY, SEAT BOTTOM BONDED	1		1
-33	22-93510-15	. . PAN, SEAT BOTTOM, RIVETED	1		1
-34	22-93557-7	. SPRING	1		1
-35	BN1-1803A18-28-1358	. BELT, SAFETY, CONVAIR 90-63801-005 -V00652-	1		1

FORWARD FACING AFT ATTENDANT'S SEAT - STA 1439
(Convair Part No. 22-93529-3)

ATA NO. 25-3-4

CONVAIR MODEL 30 OVERHAUL INSTRUCTIONS WITH ILLUSTRATED PARTS BREAKDOWN

Applicable to Model 30-5.

May 20/62

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Chapter 25

FORWARD FACING AFT ATTENDANT'S SEAT - STA 1439
(Convair Part No. 22-93529-3)

1. Description and Operation

A. Description.

The forward facing aft attendant's seat, Convair part number 22-93529-3, consists of a structural seat assembly upholstered with padding, cushions, and seat covers. The seat assembly is supported by two leg assemblies.

B. Leading Particulars.

(1) Seat width.....17.15 inches
(2) Seat length.....20.25 inches
(3) Height (from base of seat to top of seat back).....20.00 inches

C. Operation.

The forward facing aft attendant's seat assembly is hinged to the airplane structure at two points and is supported on the bottom by two leg assemblies. One end of the leg assemblies are hinged to the airplane structure. The other end of the leg assemblies are mounted in tracks on the bottom of the seat. The leg assemblies slide on the tracks when the seat is moved in or out of the stowed position. A spring-loaded latch, mounted to the bottom of the seat, latches to the rear leg assembly when the seat is being used. The latch holds the seat in the open position by preventing the rear leg assembly from sliding in the track.

2. Disassembly

A. Disassemble as follows:

(1) (See IPC Figure 1.) Release fasteners attaching safety belt (1) to the seat. Unlace shoulder harness (2) from harness plate (21). Remove the safety belt and the shoulder harness from the seat.

(2) Slide leg assemblies (3) off of the tracks on the bottom of the seat.

(3) Remove pin (4) and bushings (5) from leg (7). Remove blocks (6) from the leg by removing the attaching AN470DD6 rivets.

(4) Remove cover assembly (8) from the seat back by removing the attaching screws (9) and washers (10).

(5) Remove cover assembly (11) from the seat bottom by removing the attaching screws (12) and washers (13).

(6) Remove cushions (14) and (15) from the seat assembly.

NOTE: The cushions are tacked to the seat with a rubber base cement. Moisten the cement with solvent specified in paragraph 6.B. (1)(b). Using a sharp instrument, pry the cushion from the seat.

(7) If damaged, remove pads (16) and (17) from the seat.

NOTE: The pads are attached to the seat with a rubber base cement. Use solvent specified in paragraph 6.B.(1)(b) to soften the cement before removing the pads.

(8) Remove pan (18) from the bottom of the seat.

NOTE: Pan (18) is attached to the seat with a rubber base cement. Moisten the cement with solvent specified in paragraph 6.B. (1)(b). Using a sharp instrument, pry the pan from the seat.

(9) If damaged, remove pad (19) from the bottom of the seat.

NOTE: The pad is attached to the seat with a rubber base cement. Use solvent specified in paragraph 6.B.(1)(b) to soften the cement before removing the pad.

(10) Remove shoulder harness plate (21) from seat assembly (20) by removing the four attaching bolts (22).

(11) Remove rivets (23). Remove washers (24), washer (25), bushings (26), and links (27) from the seat assembly.

(12) Remove lock assembly (28) from the seat assembly by removing bolt (29), spacers (30), and washers (31).

(13) Disassemble the lock assembly by removing the AN426B4 rivets attaching knob (32) to lever (33).

(14) Remove spring (34) from seat assembly (20) by removing the attaching rivets (35).

(15) Remove bumper (36) from the seat assembly.

(16) Remove stop (37) from the seat assembly by removing the attaching screws (38).

NOTE: If shims are installed under stop (37), retain the shims for installation.

(17) Remove bushings (39) from the seat assembly.

3. Cleaning

A. General.

(1) Use soap and water or any standard commercial dry-cleaning procedure on the covers, safety belt, and shoulder harness.

(2) Use soap and water to clean foam rubber.

(3) Using solvent specified in paragraph 6.B.(1)(b), clean cement residue from the seat.

(4) (See IPC Figure 1.) Remove dirt from surface of pan (18) with a mild soap and water solution. After cleaning, rinse the pan with water and dry it with a clean cloth. Wash the pan with cleaner specified in paragraph 6.B.(1)(a) to remove grease marks. Rinse the pan with clean water and dry it with cheese cloth.

NOTE: The cleaner specified in paragraph 6.B.(1)(a) must be diluted by adding 1 to 3 parts water.

4. Inspection

A. Where doubt exists concerning the serviceability of standard AN, NAS, and MS parts, replace the parts.

B. Under a strong light and preferably under magnification, inspect all parts as applicable for nicks, cracks, cuts, chafing, scoring, and excessive wear.

5. Repair

Not applicable.

6. Assembly

A. Assemble as follows:

(1) (See IPC Figure 1.) Install bushings (39) on seat assembly (20).

(2) Attach stop (37) to the seat assembly with screws (38).

NOTE: If shims were installed under the stop, replace the shims.

(3) Install bumper (36) on the seat assembly.

(4) Attach spring (34) to the seat assembly with rivets (35).

(5) Attach knob (32) to lever (33) with AN426B4 rivets.

(6) Install lock assembly (28) on the seat assembly using washers (31), spacer (30), and bolt (29).

(7) Install bushings (26), washers (24), washers (25), and links (27) on the seat assembly with rivets (23).

(8) Install shoulder harness plate (21) on the seat assembly with bolts (22).

(9) Attach pad (19) to the bottom of the seat with cement specified in paragraph 6.B.(1)(c).

(10) Attach pan (18) to the bottom of the seat with cement specified in paragraph 6.B.(1)(c).

(11) Attach pads (16) and (17) to the seat with cement specified in paragraph 6.B.(1)(c).

(12) Using cement specified in paragraph 6.B.(1)(c), tack cushions (14) and (15) to the seat assembly.

(13) Install cover assembly (11) on the seat bottom with screws (12) and washers (13).

(14) Install cover assembly (8) on the seat back with screws (9) and washers (10).

(15) Install blocks (6) on leg (7) using AN470DD6 rivets.

(16) Install bushings (5) and pin (4) on leg (7).

(17) Attach safety belt (1) to the seat assembly. Lace shoulder harness (2) through harness plate (21).

(18) Slide leg assemblies (3) onto the tracks on the bottom of the seat.

B. Materials.

(1) Use the following materials, or equivalent.

	MATERIAL	IDENTIFICATION	SOURCE
(a)	Cleaner	VCCX-20, Group X	Jackson Chemical Co. Los Angeles, California
(b)	Toluene Solvent	Federal Specification TT-T-548	Optional
(c)	Cement Stabond	T-161	American Latex Products Corporation Los Angeles, California

MATERIAL	IDENTIFICATION	SOURCE
(d) Wrapping Paper	Federal Specification VV-P-271	Optional
(e) Tape	Federal Specification JAN-P-127	Optional

7. Fits and Clearances

Not applicable.

8. Testing

A. Test safety belt and shoulder harness to current FAA requirements.

9. Trouble Shooting

Not applicable.

10. Storage Instructions

A. Wrap the seat in wrapping paper specified in paragraph 6.B.(1)(d), or in a plastic bag. Secure the wrapping paper or plastic bag on the seat with tape specified in paragraph 6.B.(1)(e).

11. Special Tools, Fixtures, and Equipment

Not applicable.

ILLUSTRATED PARTS BREAKDOWN

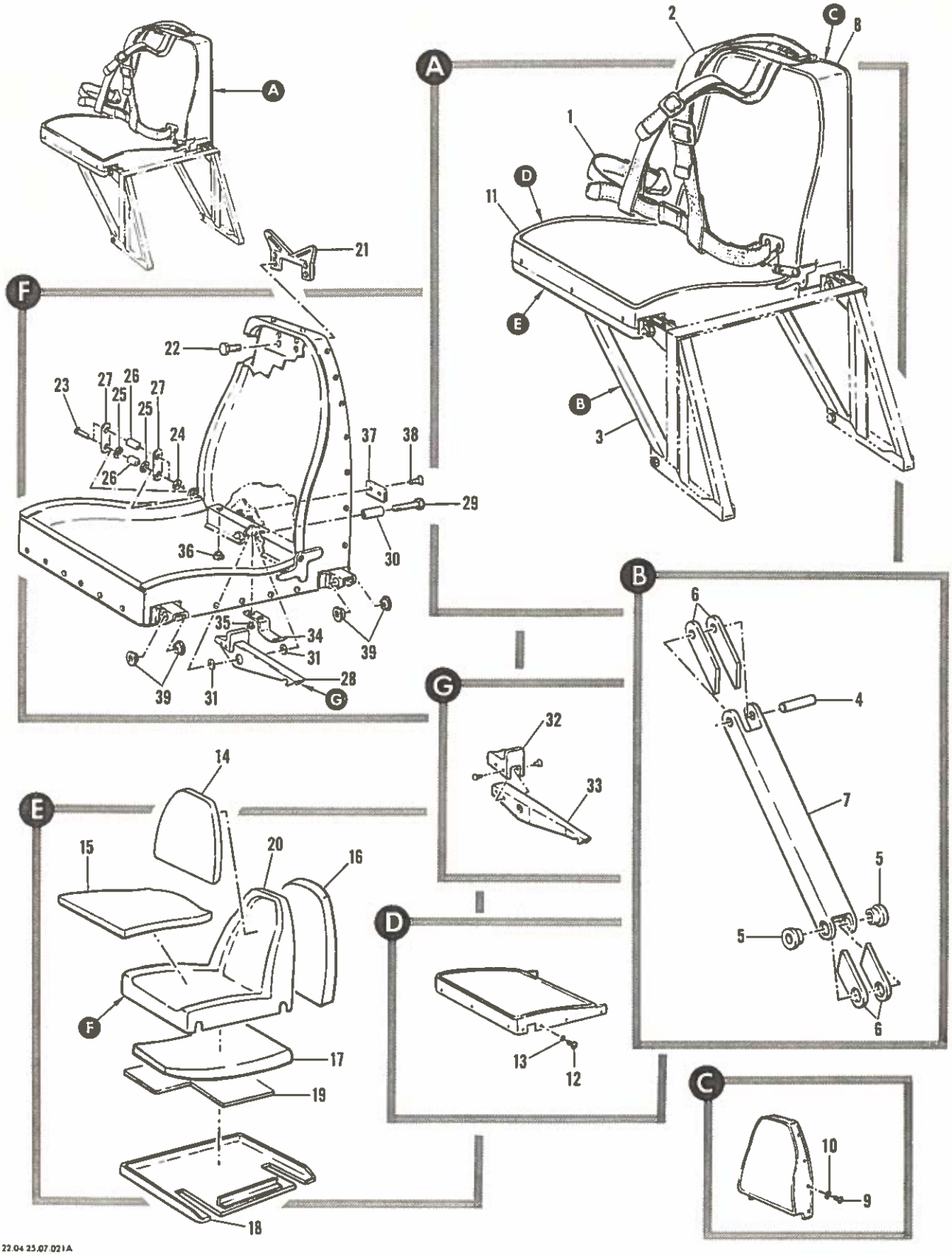
FORWARD FACING AFT ATTENDANT'S SEAT - STA 1439
(Convair Part No. 22-93529-3)

ATA NO. 25-3-4

Applicable to Model 30-5. May 20/62

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FIGURE AND INDEX NO.	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	USAGE CODE FROM	USAGE CODE TO	UNITS PER ASSEMBLY
1	22-93529-3	SEAT INSTALLATION, FWD FACING AFT ATTENDANT	1		REF
- 1	BN1-1513A15-22-	. BELT, 1370 SAFETY CONVAIR 90-63801-013 -V01345-	1		1
- 2	BN1514-1	. HARNESS, SHOULDER CONVAIR 94-58000-011 -V01345-	1		1
- 3	22-93529-21	. LEG ASSEMBLY, SEAT FOR SPARES USE 22-93529-21P	1		2
	22-93529-21P	. LEG ASSEMBLY, SEAT	1		REF
- 4	96-79700-182	. . PIN	1		1
- 5	NAS77-4-15	. . BUSHING	1		2
- 6	22-93529-17	. . BLOCK, RADIUS	1		4
- 7	22-93529-19	. . LEG	1		1
- 8	22-93507-5	. COVER ASSEMBLY, SEAT BACK CUSHION	1		1
- 9	8-32NC2AX625	. . SCREW, CONVAIR 97-89025-013 -V42689-	1		11
- 10	61-3208	. . WASHER, CONVAIR 99-51405-001 -V42689-	1		11
	22-93507-51	. . RETAINER, BOTTOM SIDE	1		2
	22-93507-53	. . RETAINER, SIDE	1		2
	22-93507-55	. . RETAINER, TOP	1		1
	22-93507-9	. . COVER	1		1
- 11	22-93507-1	. COVER ASSEMBLY, SEAT BOTTOM CUSHION	1		1
- 12	8-32NC2AX625	. . SCREW, CONVAIR 99-89025-013 -V42689-	1		12
- 13	61-3208	. . WASHER, CONVAIR 99-51405-001 -V42689-	1		12
	22-93507-57	. . RETAINER, SIDE	1		1
	22-93507-59	. . RETAINER, SIDE	1		1
	22-93507-47	. . RETAINER, BOTTOM FWD	1		1
	22-93507-7	. . COVER	1		1
	22-93529-7	. SEAT ASSEMBLY, AFT ATTENDANT	1		1
- 14	22-93525-7	. . CUSHION, SEAT BACK	1		1
- 15	22-93520	. . CUSHION ASSEMBLY, SEAT BONDED	1		1
- 16	22-93529-27	. . PAD, SEAT BACK	1		2
- 17	22-93529-29	. . PAD, SEAT	1		1
- 18	22-93528	. . PAN ASSEMBLY, BONDED	1		1
- 19	22-93529-9	. . PAD, SEAT BOTTOM	1		1
- 20	22-93505	. . STRUCTURE ASSEMBLY, ATTENDANT SEAT	1		1
- 21	22-93902	. . . PLATE, SHOULDER HARNESS	1		1
		ATTACHING PARTS			
- 22	AN4-5A	. . . BOLT	1		4
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- 23	97-67002-078	. . . RIVET	1		4
- 24	AN960C101	. . . WASHER	1		4
- 25	AN960C516L	. . . WASHER	1		4
- 26	91-27004-038	. . . BUSHING	1		4
- 27	22-93510-43	. . . LINK	1		4
	22-93505-33	. . . PLATE, FOR SPARES USE 22-93505-33P	1		2
	22-93505-33P	. . . PLATE, CONSISTS OF 22-93505-33 WITH PILOT HOLES OMITTED	1		REF
- 28	22-93522	. . . LOCK ASSEMBLY, SEAT	1		1
		ATTACHING PARTS			
- 29	NAS1103-22	. . . BOLT	1		1
- 30	NAS73-3E106	. . . SPACER	1		1
- 31	AN960D516	. . . WASHER	1		2
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- 32	22-93527	. . . . KNOB	1		1
- 33	22-93522-7	. . . . LEVER	1		1
- 34	22-09546-3	. . . SPRING, MFR TO SPEC CONT 22-09546-3 -V04811- P	1		1
		ATTACHING PARTS			
- 35	AN470AD5	. . . RIVET	1		2
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- 36	91-18002-003	. . . BUMPER, RUBBER	1		1
- 37	22-93505-45	. . . STOP	1		1
		ATTACHING PARTS			
- 38	NAS1203-3	. . . SCREW	1		1
		----X----			
	22-93505-13	. . . PAN, SEAT	1		1
	22-93505-17	. . . PAN, BACK	1		1
- 39	NAS77-4-15	. . . BUSHING	1		4